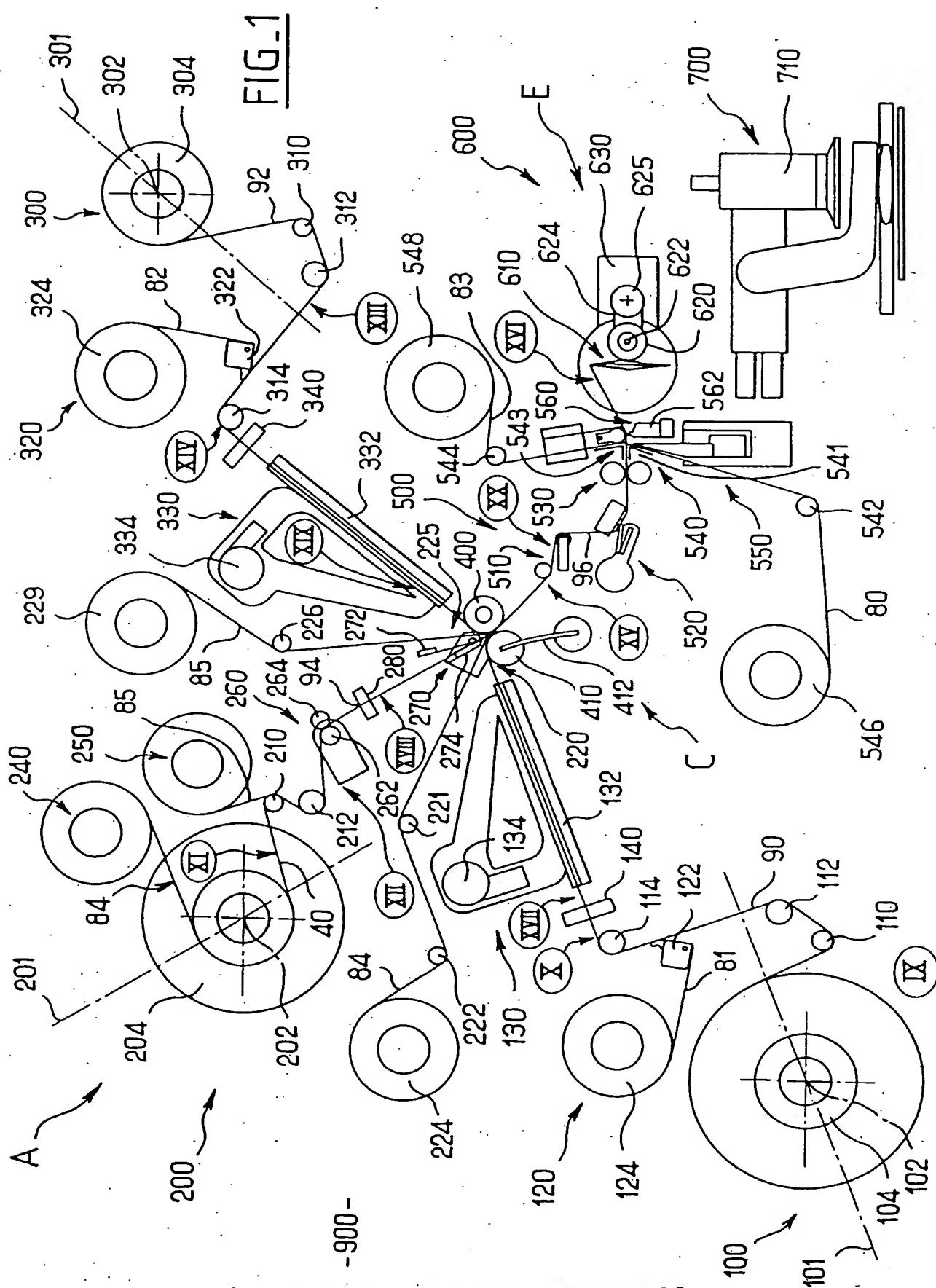


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FIG. 2

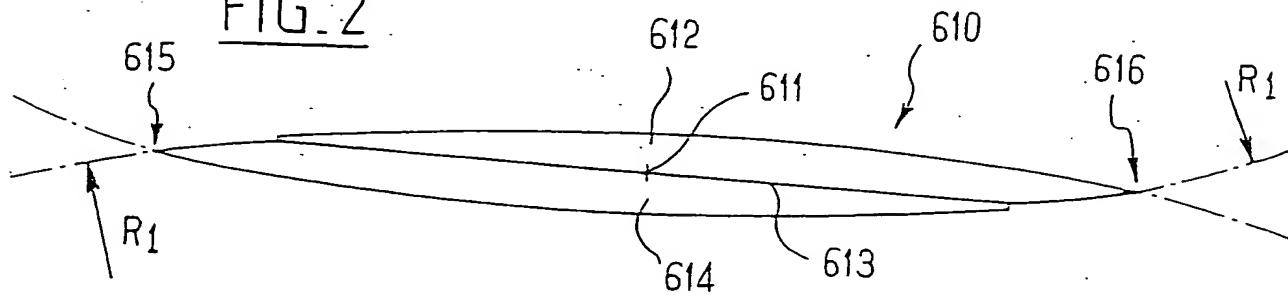


FIG. 3

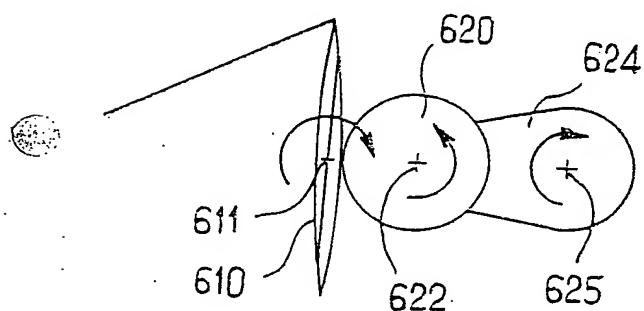


FIG. 4

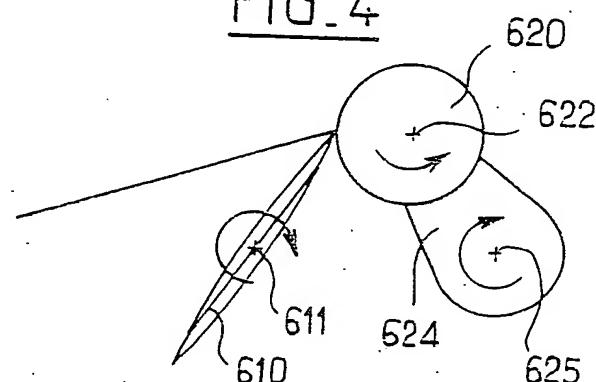


FIG. 5

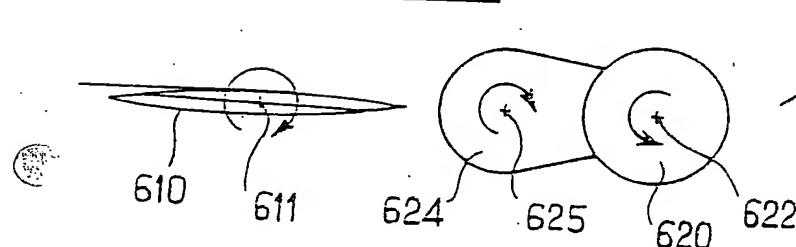


FIG. 6

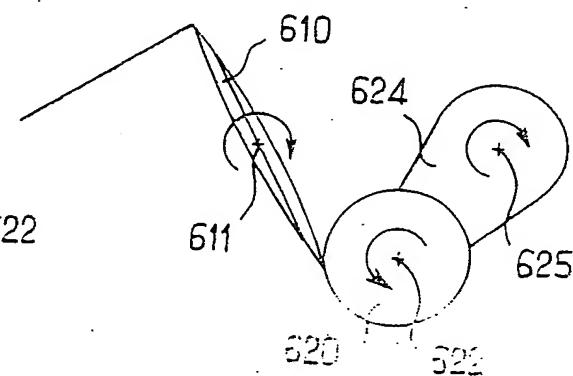
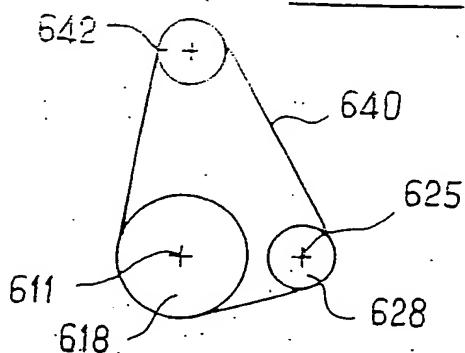
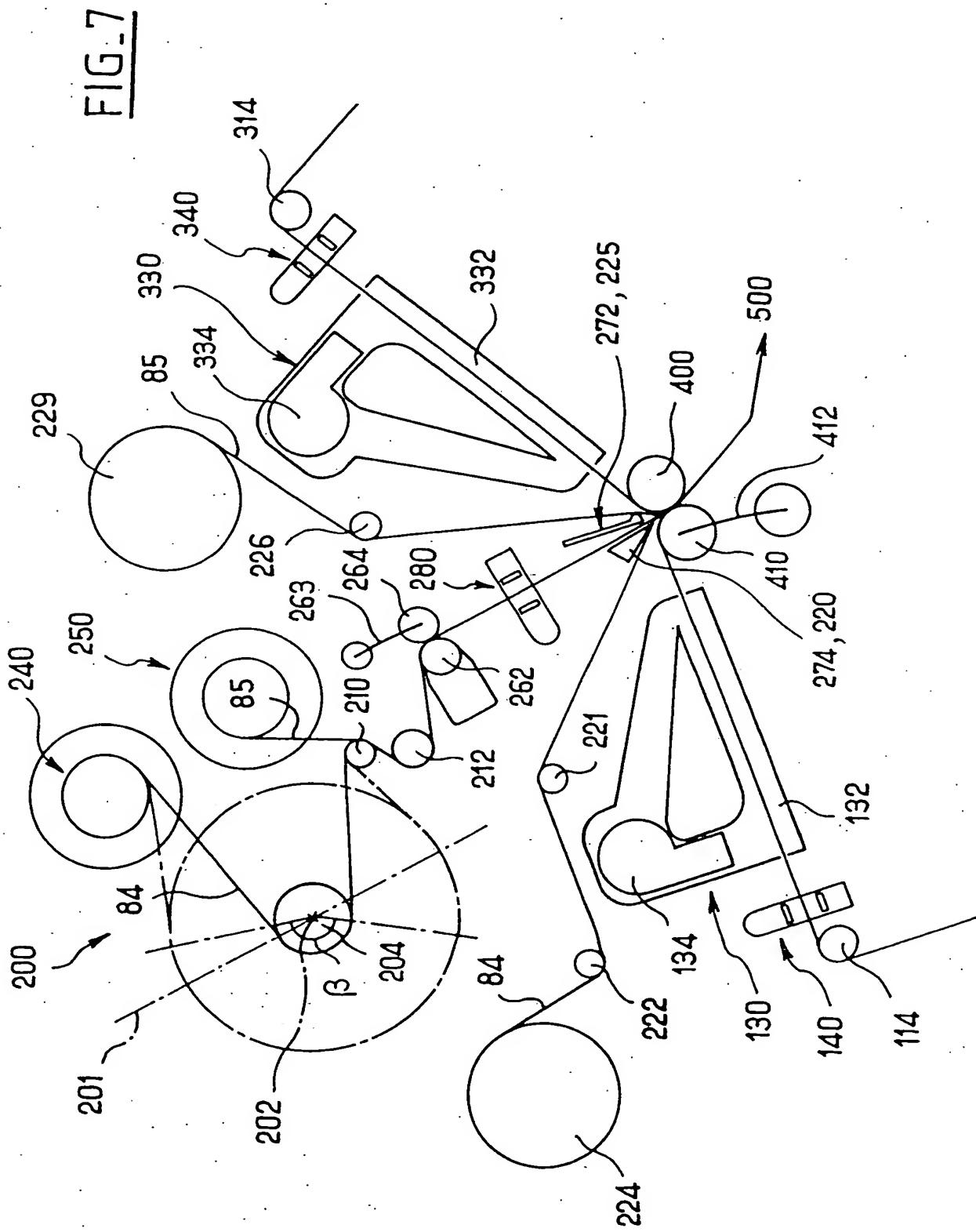


FIG. 22



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FIG. 8

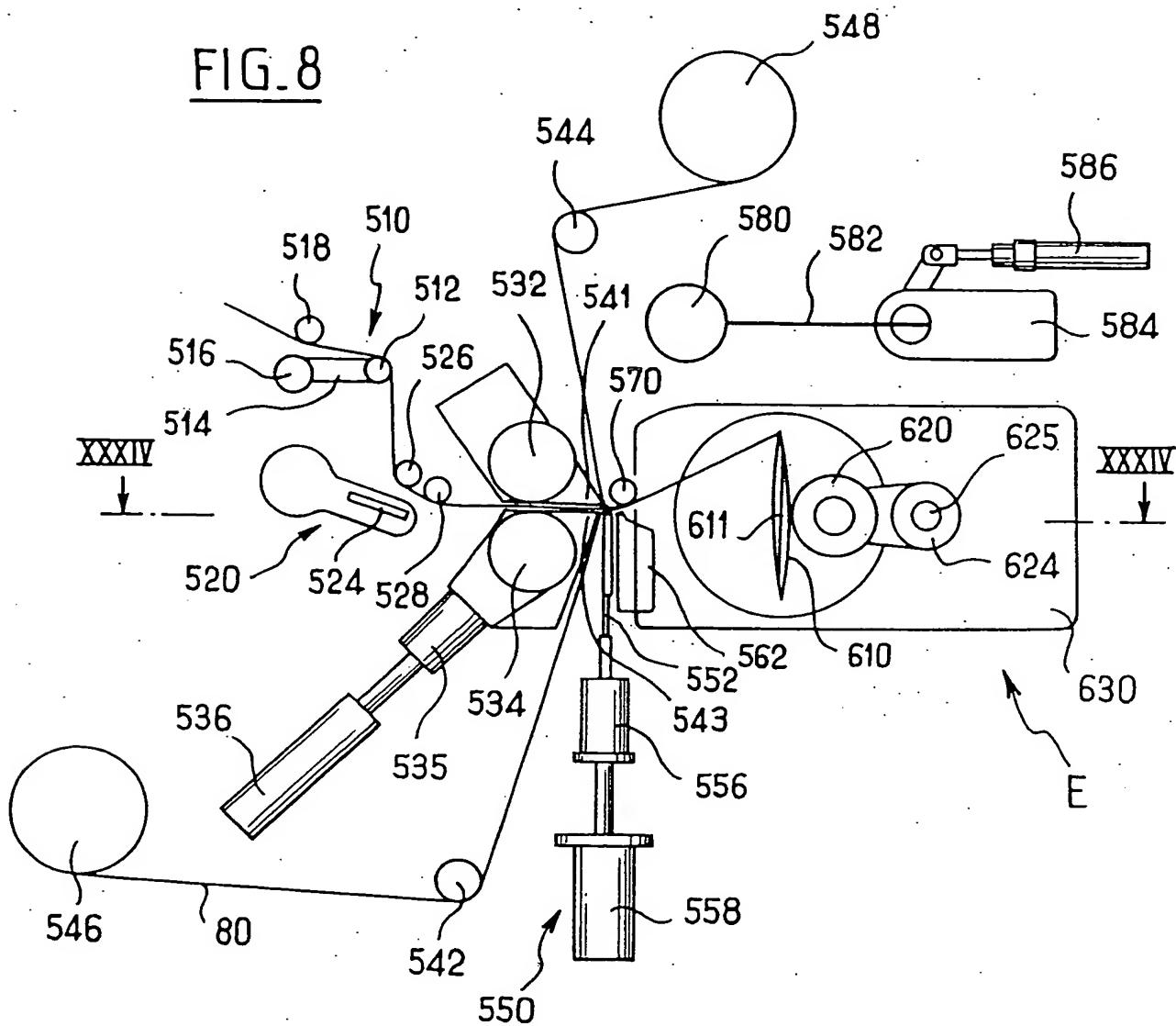
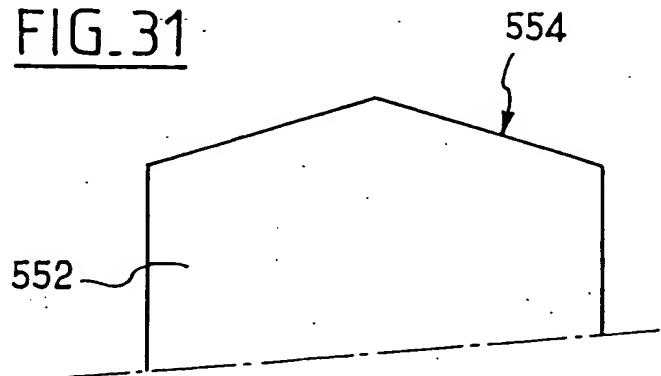
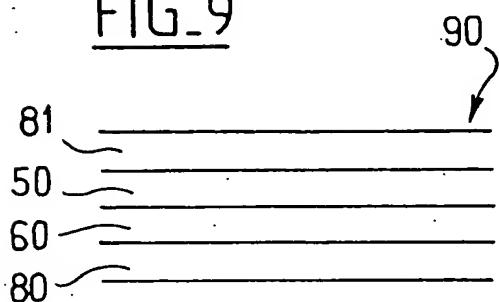


FIG. 31

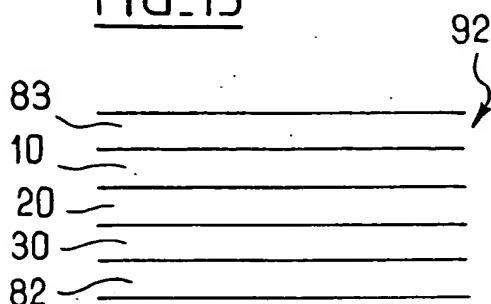


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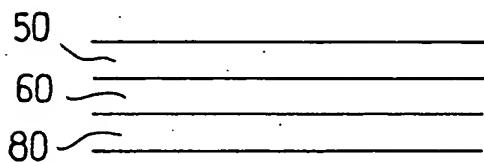
FIG\_9



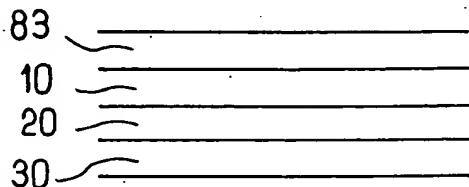
FIG\_13



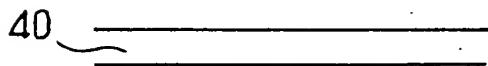
FIG\_10



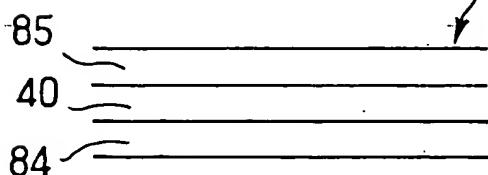
FIG\_14



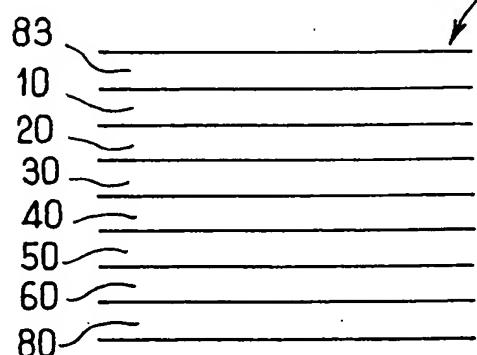
FIG\_11



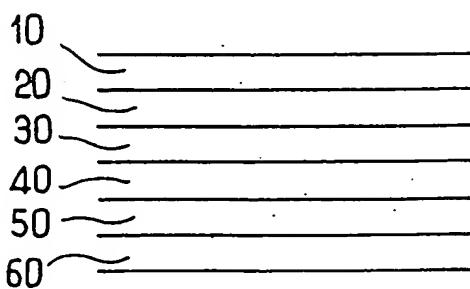
FIG\_12



FIG\_15



FIG\_16



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FIG.17

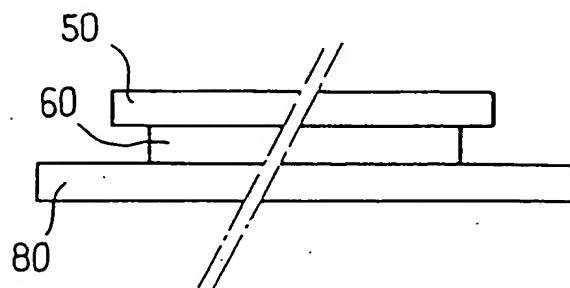


FIG.18

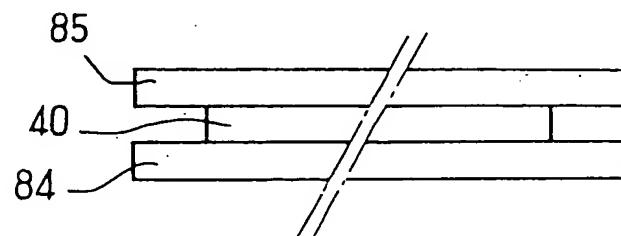


FIG.19

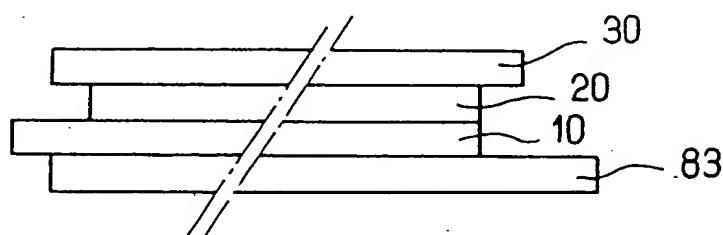
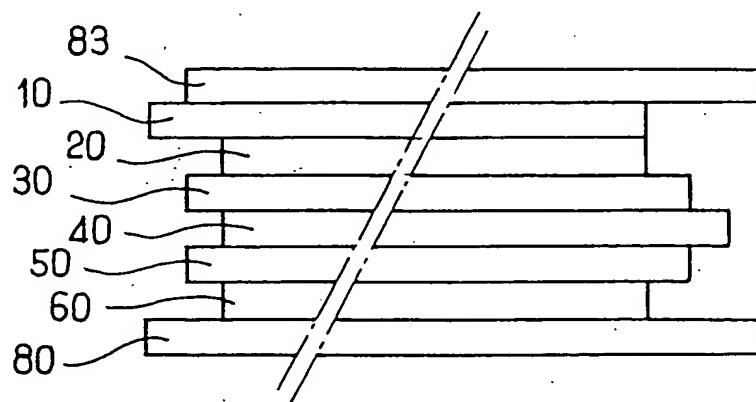


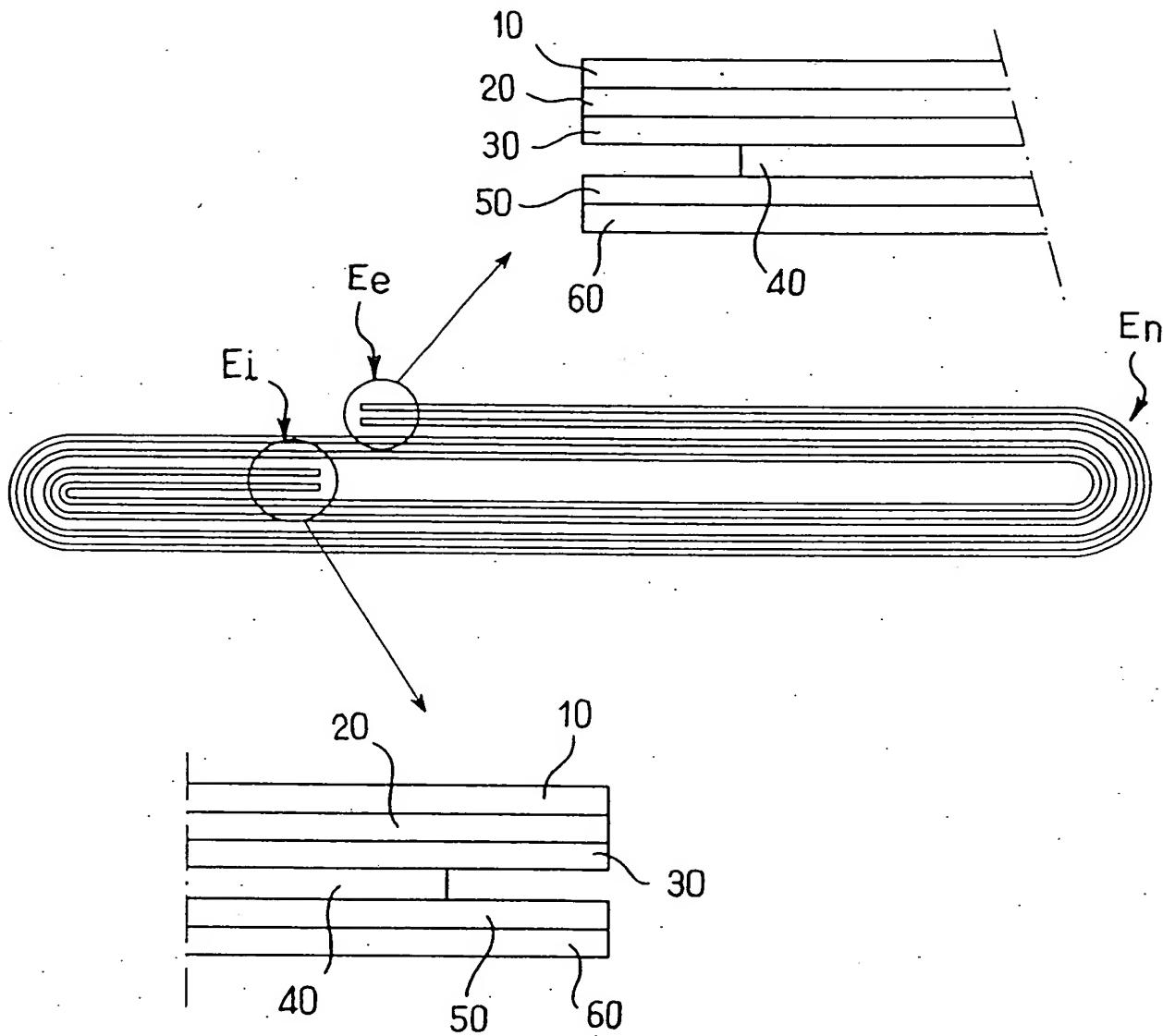
FIG.20



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FIG. 21



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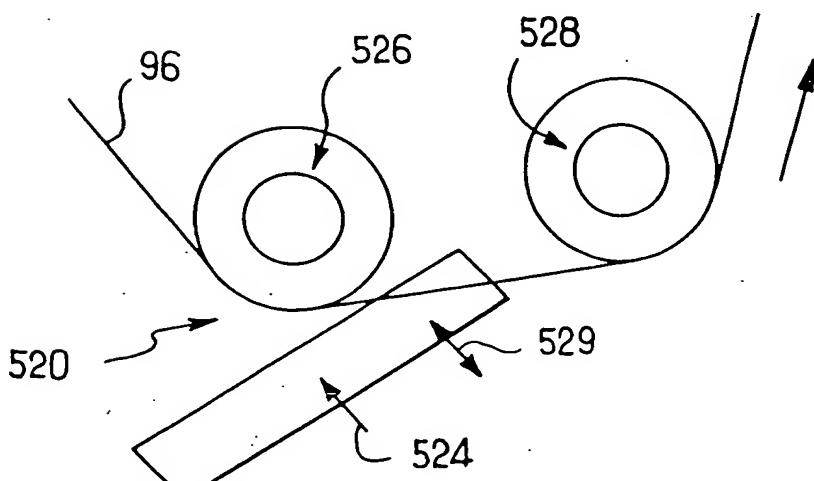


FIG. 23

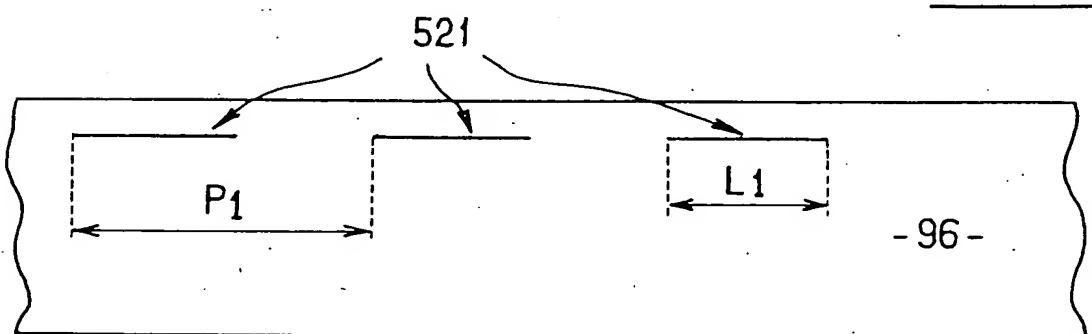


FIG. 24

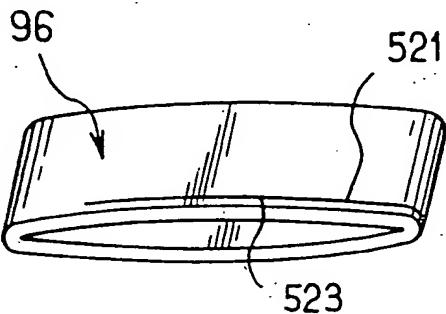


FIG. 25

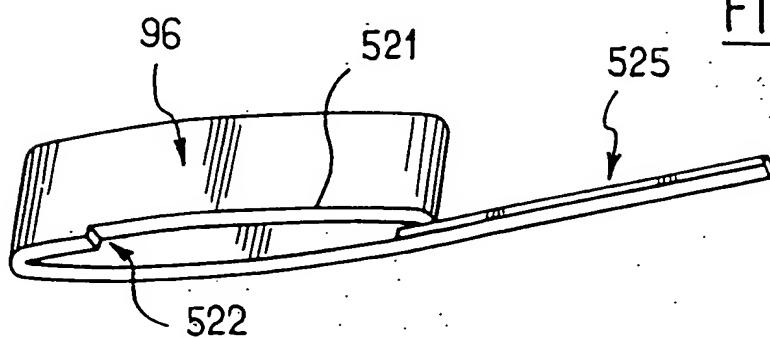


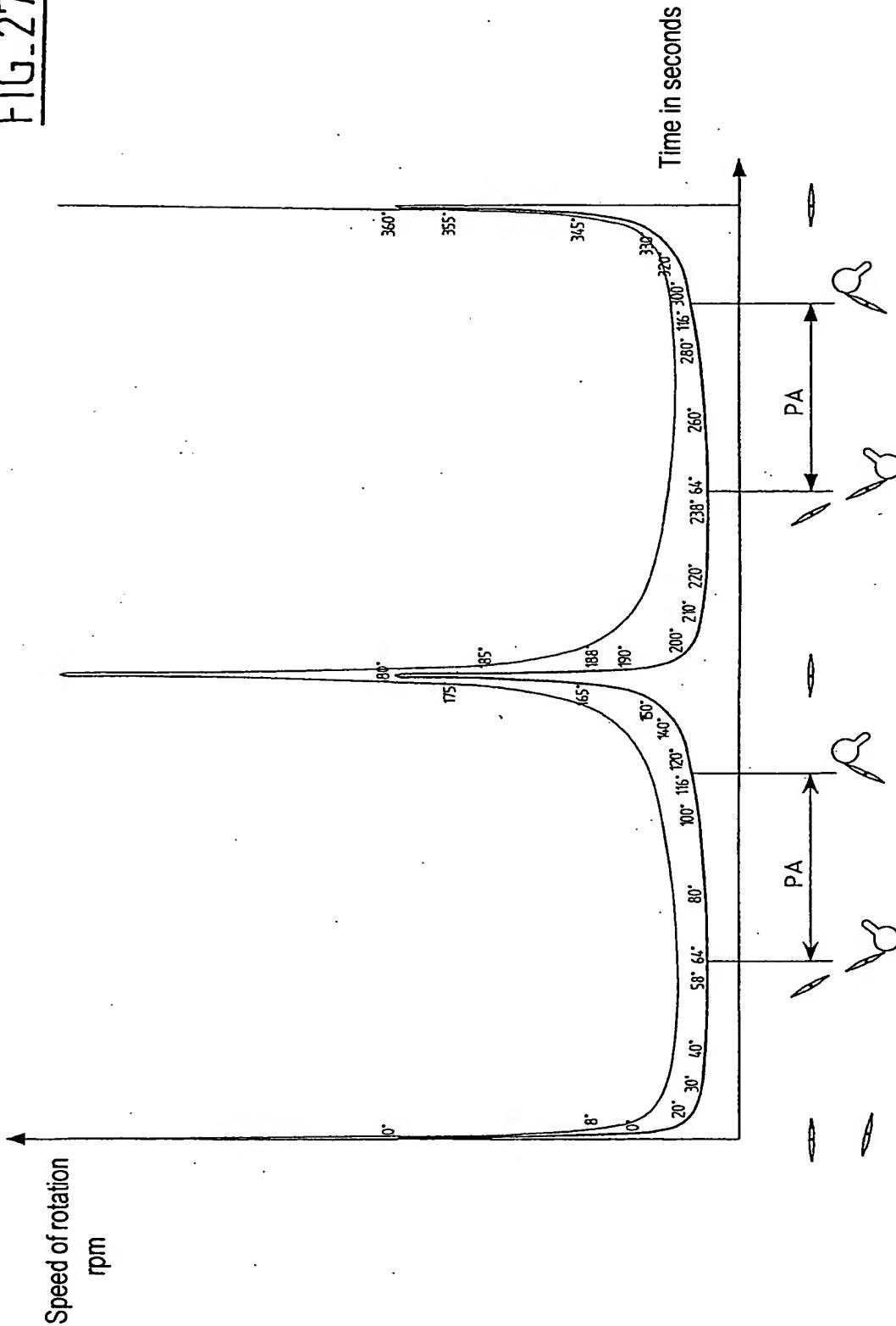
FIG. 26

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FIG. 27

Curves showing variation in mandrel speed on 1st turn at 6 m/min

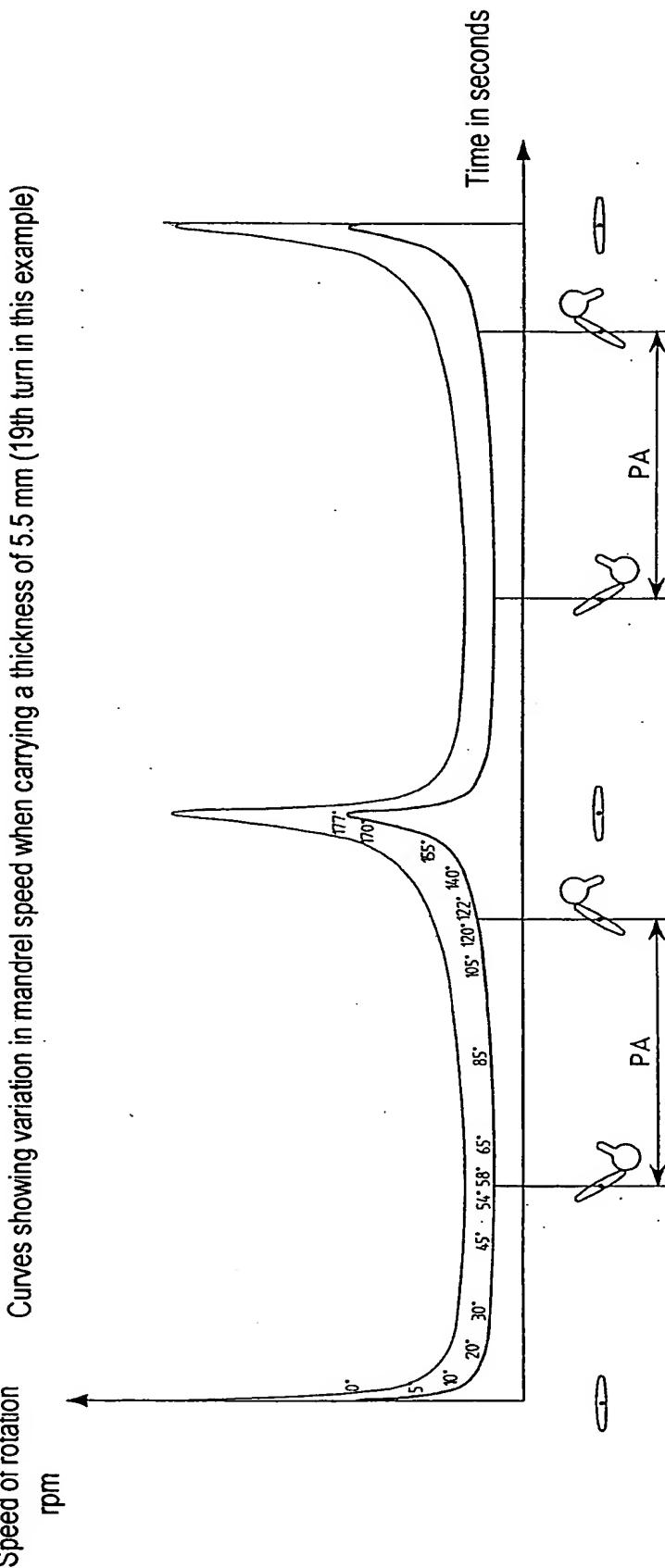


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FIG. 28

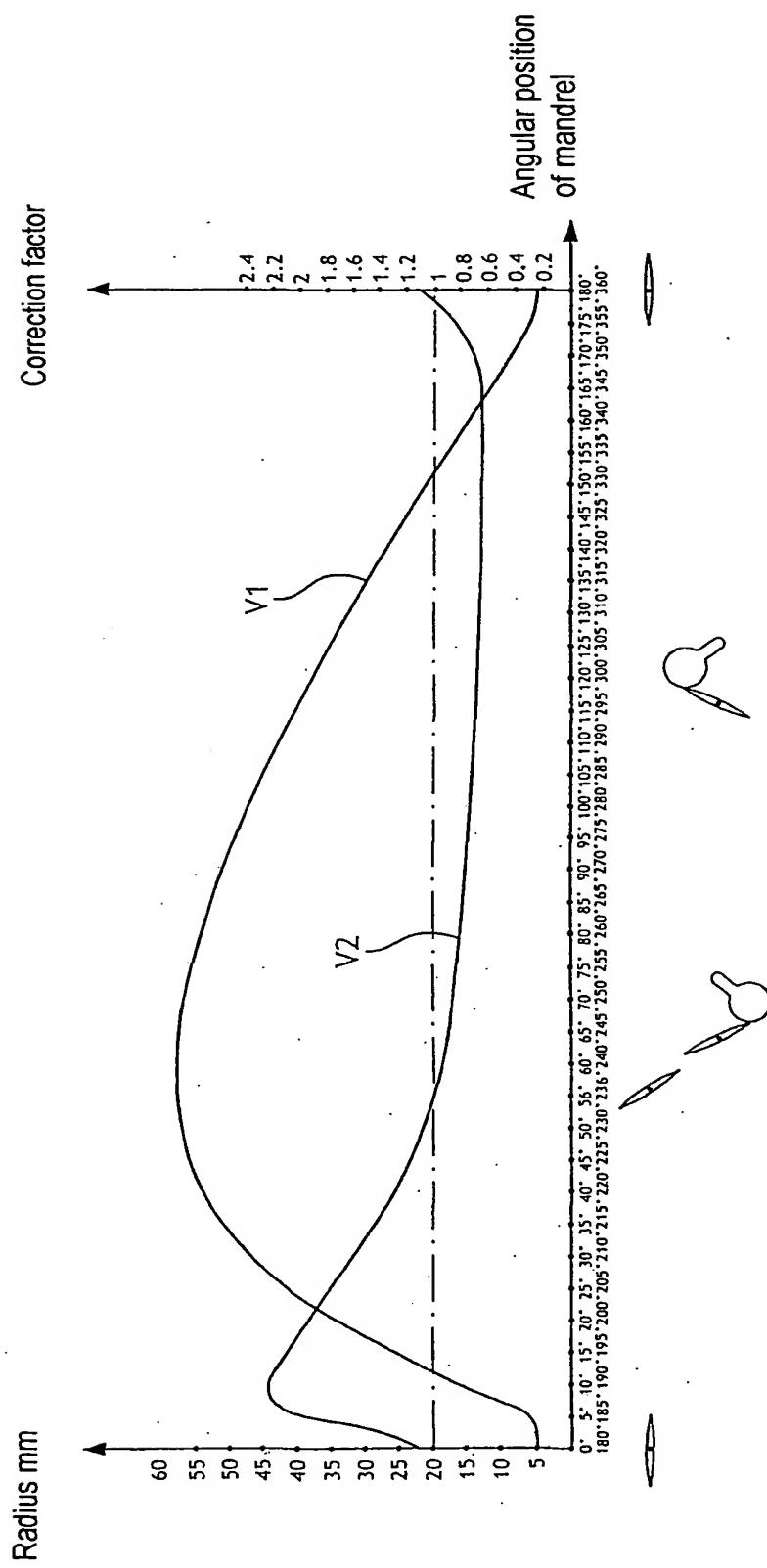
Curves showing variation in mandrel speed when carrying a thickness of 5.5 mm (19th turn in this example)



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FIG. 29



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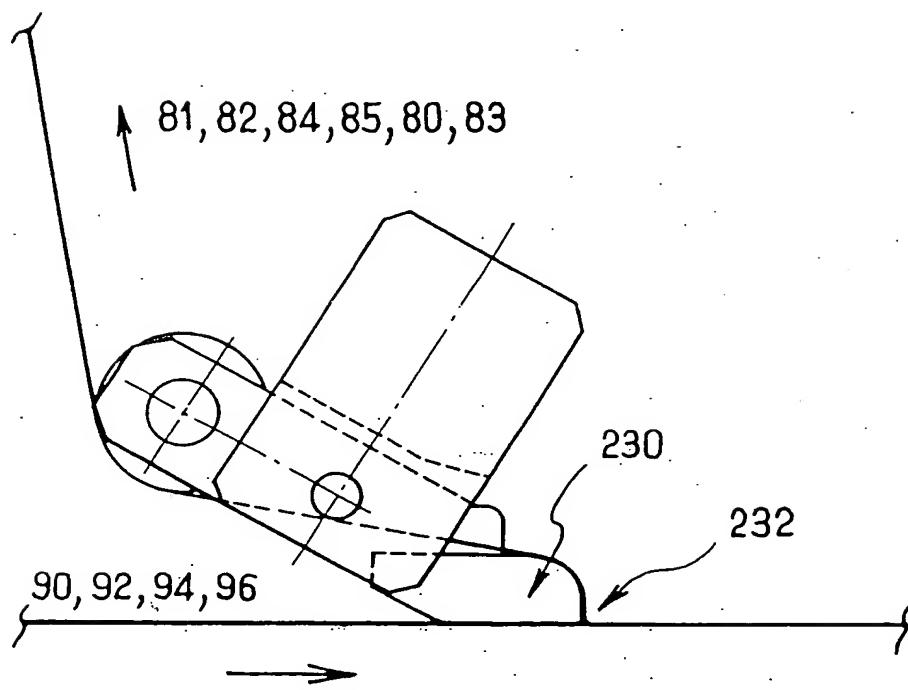
FIG. 30

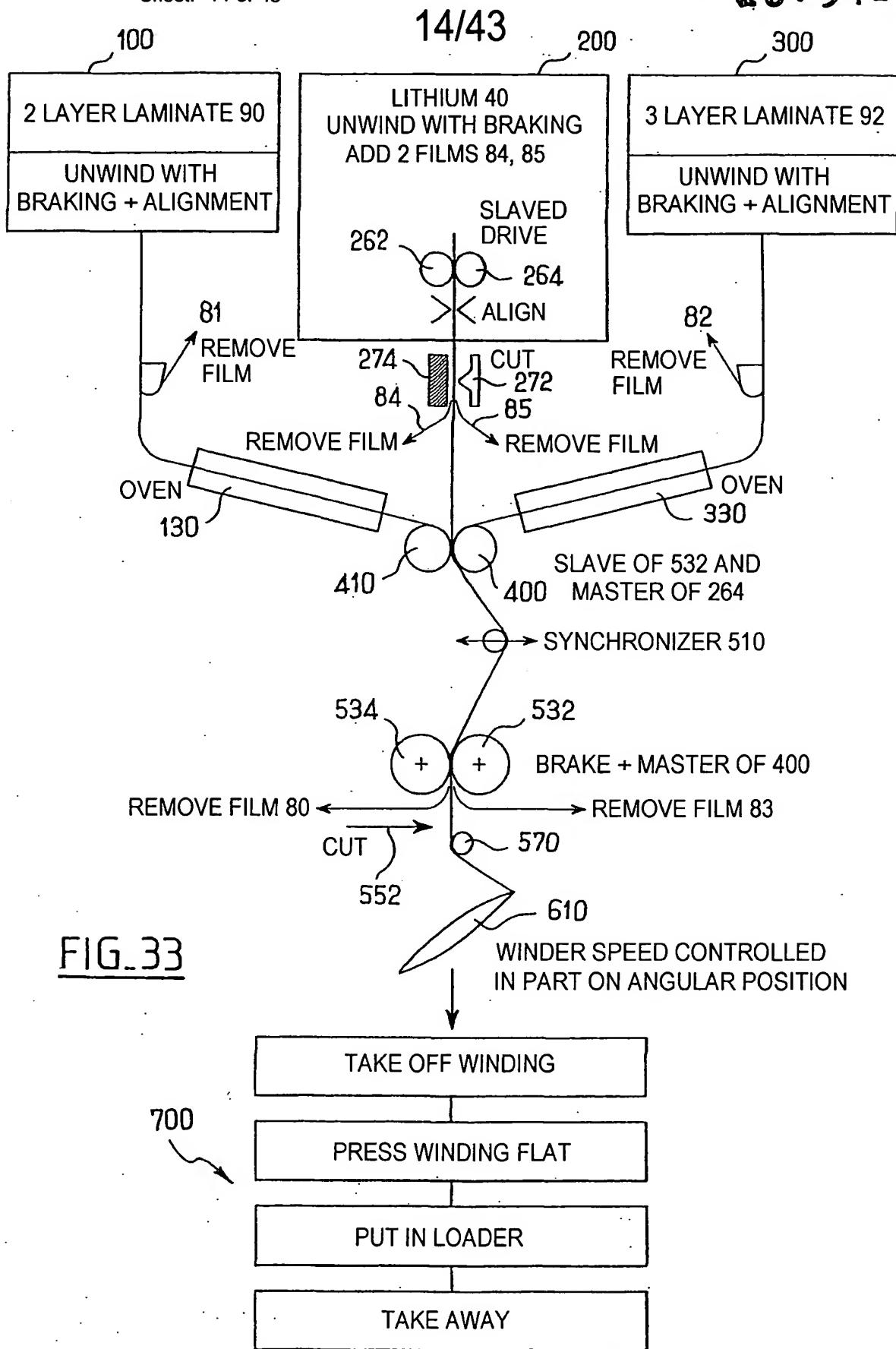
Angle in °	Winding radius	Correction factor	1st turn		2nd turn		10th turn		23rd turn		
			r	N	r	N	r	N	r	N	
0	180	5.00	1.109980	5.22	182.87	5.44	175.41	7.22	132.26	10.11	94.49
1	181	5.06	1.200700	5.30	180.17	5.54	172.36	7.46	127.98	10.58	90.23
2	182	5.24	1.319033	5.50	173.50	5.77	165.57	7.88	121.21	11.31	84.45
3	183	5.57	1.483629	5.87	162.77	6.16	154.93	8.54	111.85	12.39	77.04
...	...						...			...	
80	260	54.30	0.796343	54.46	17.53	54.62	17.48	55.89	17.09	57.96	16.47
85	265	52.82	0.774575	52.97	18.03	53.13	17.97	54.37	17.56	56.38	16.94
...	...						...			...	
178	358	5.19	0.977600	5.39	177.31	5.58	171.10	7.15	133.65	9.69	98.58
179	359	5.05	1.037420	5.26	181.63	5.46	174.74	7.12	134.03	9.82	97.22
180	360	5.00	1.109980	5.22	182.87	5.44	175.41	7.22	132.26	10.11	94.49

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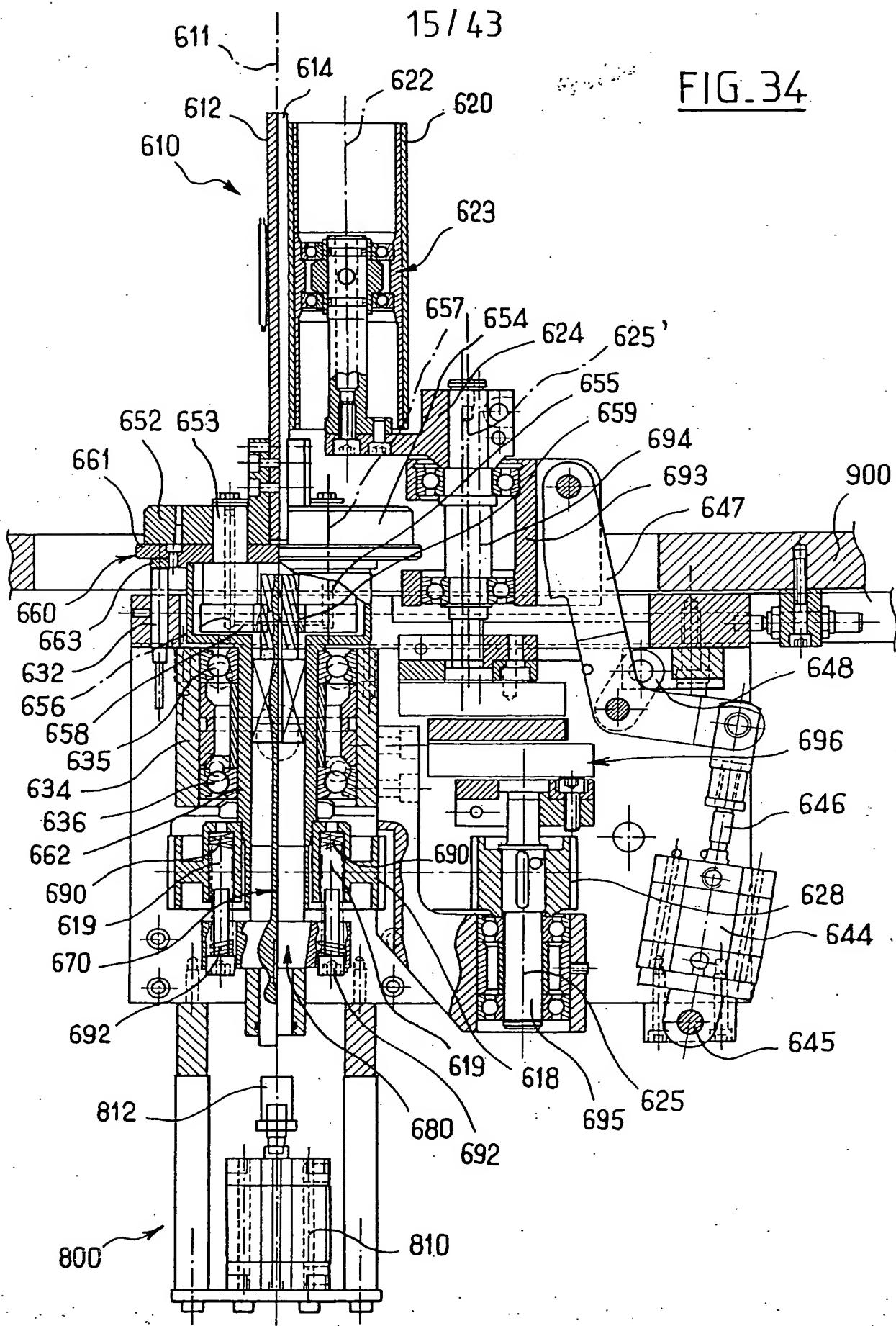
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FIG. 32





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FIG. 34

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FIG. 35

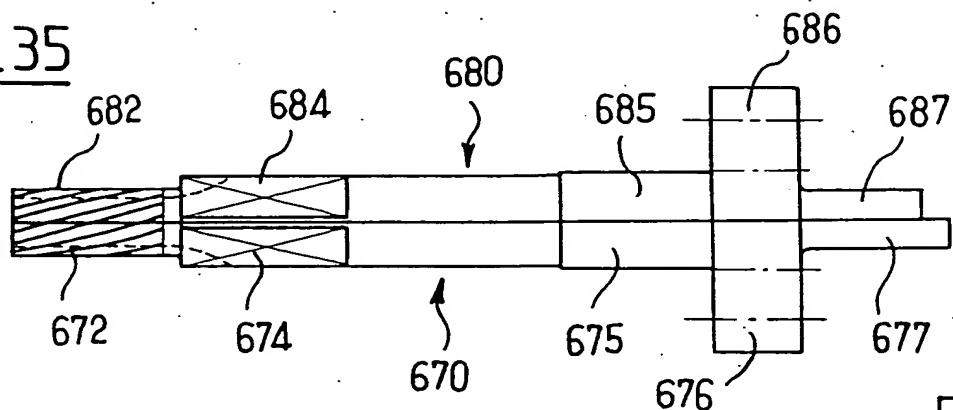


FIG. 36

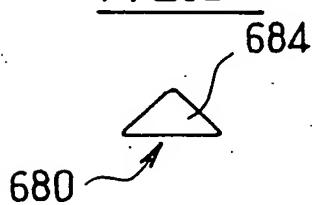


FIG. 37

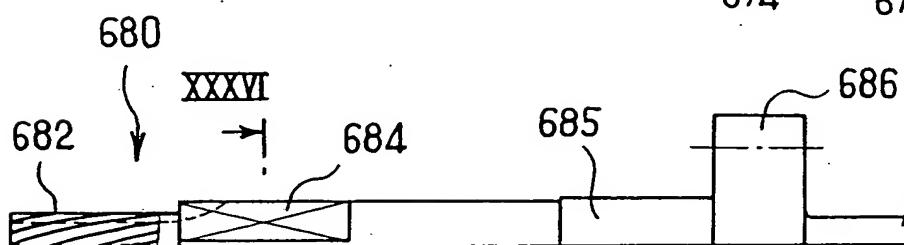
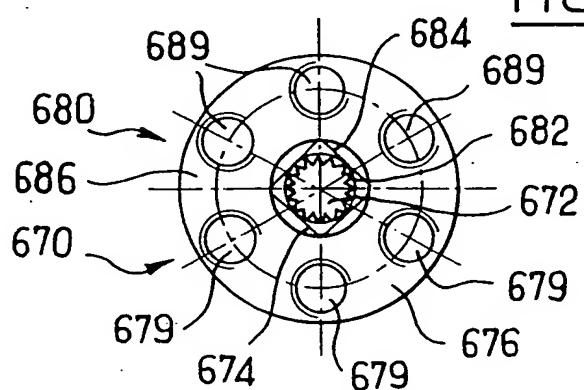


FIG. 38

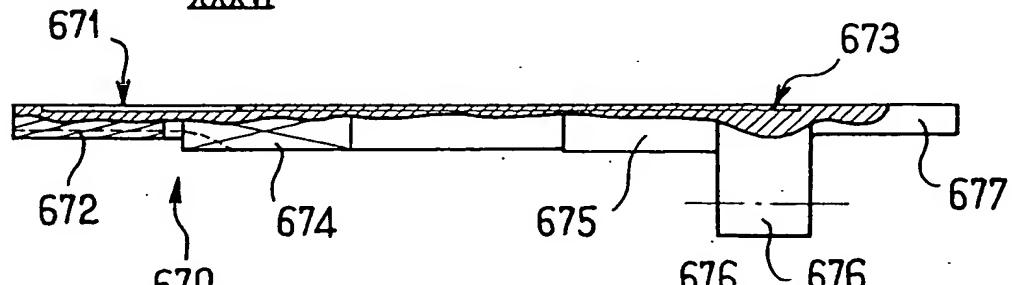


FIG. 39

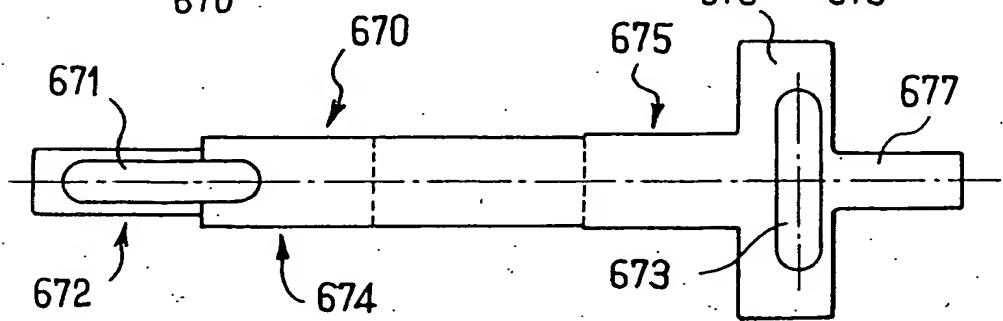
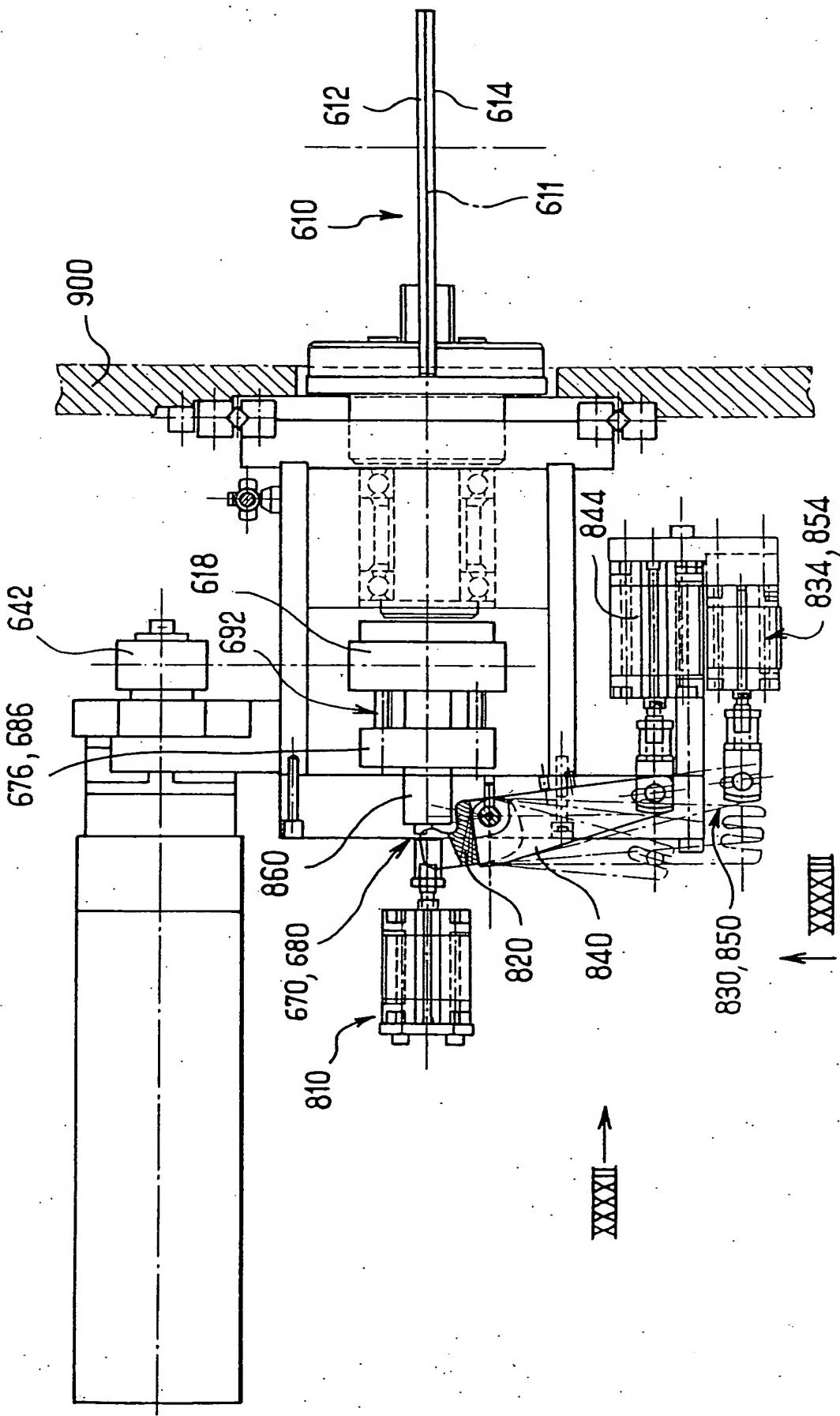


FIG. 40

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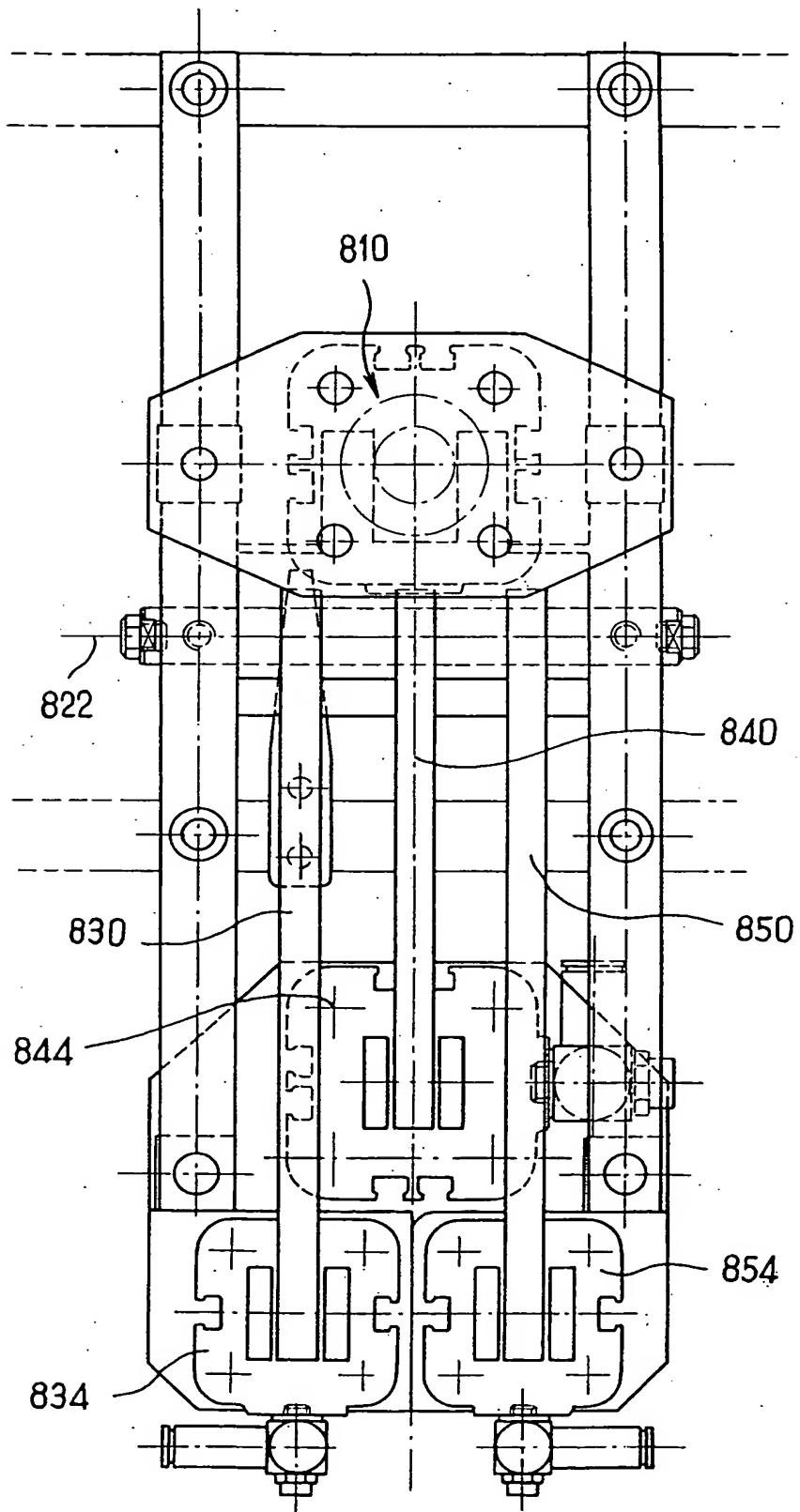
FIG. 41



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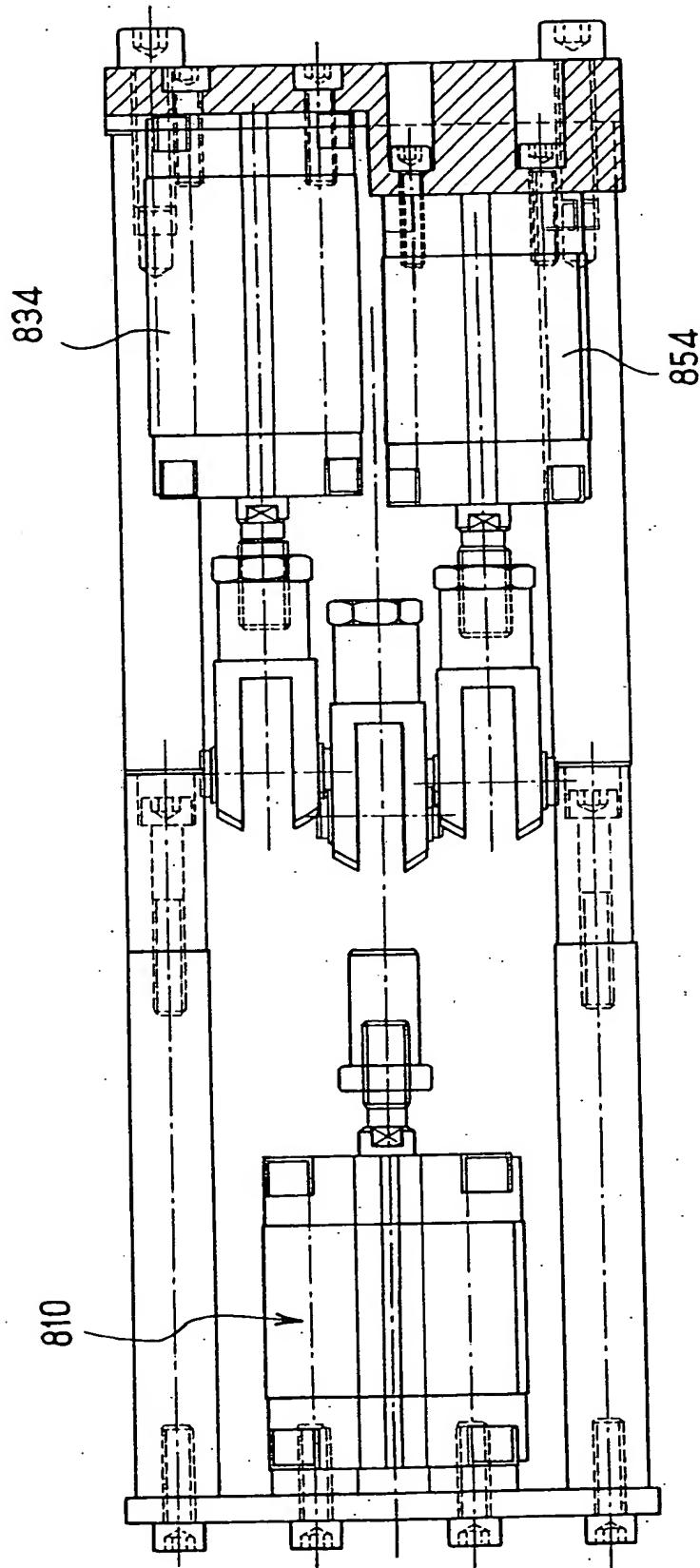
FIG. 42



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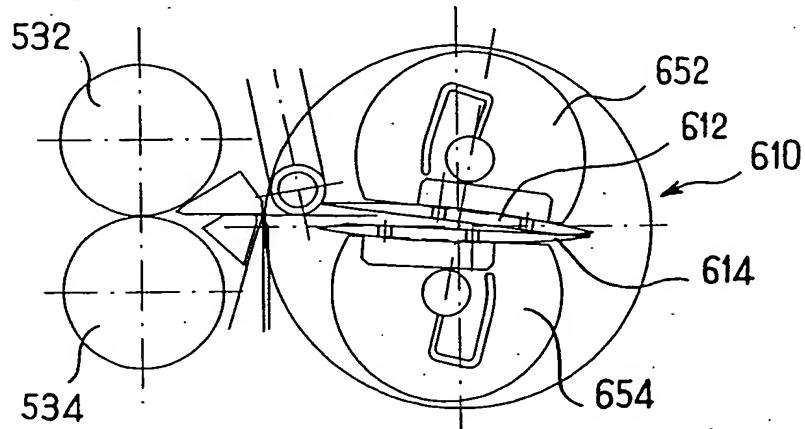
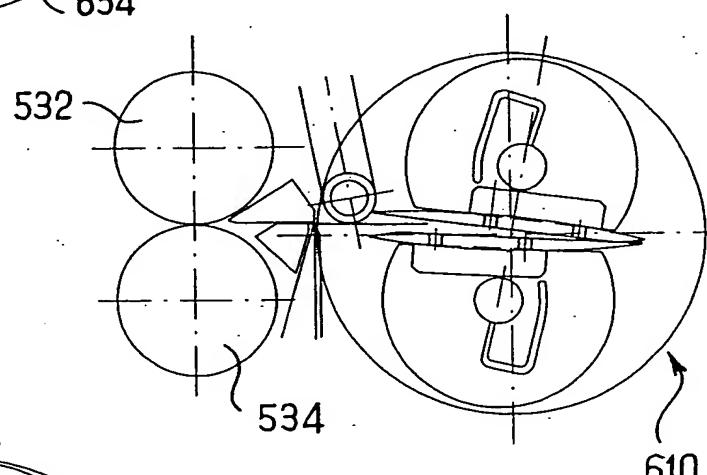
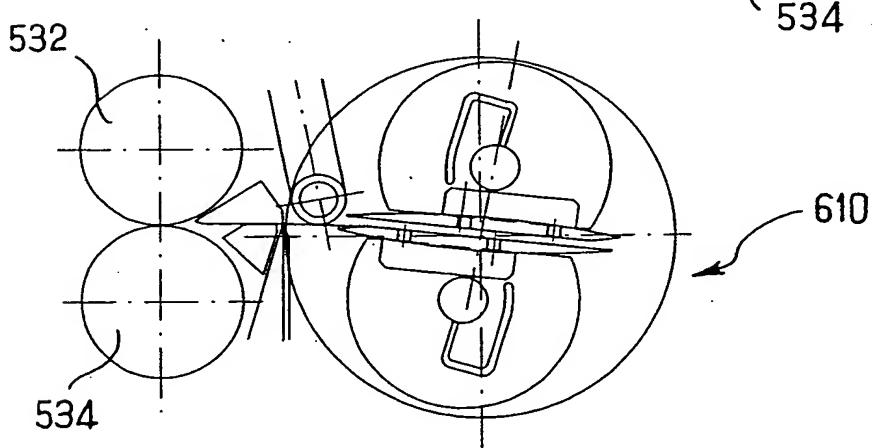
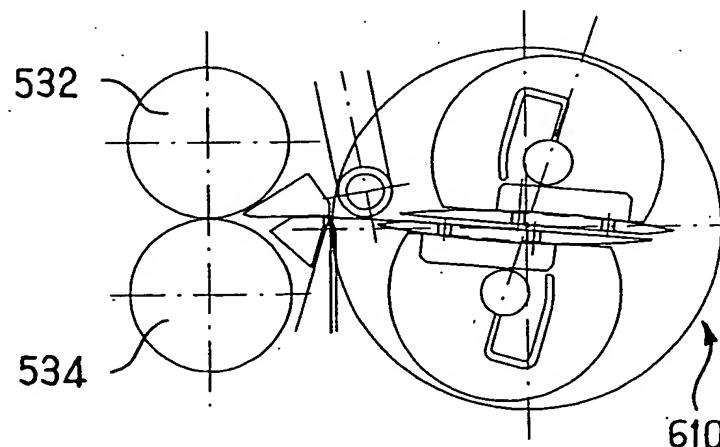
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FIG. 43



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FIG. 44AFIG. 44BFIG. 44CFIG. 44D

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FIG. 44E

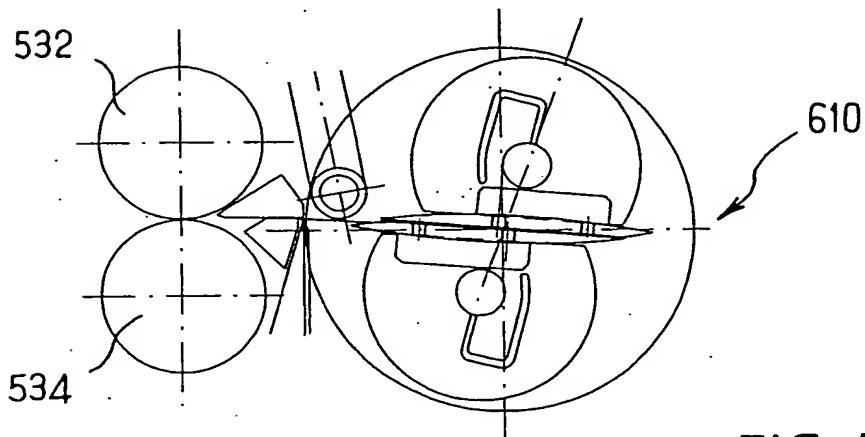


FIG. 44F

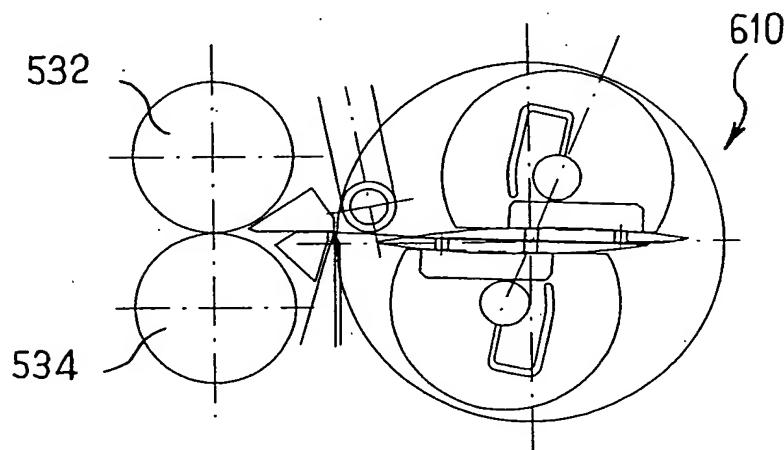
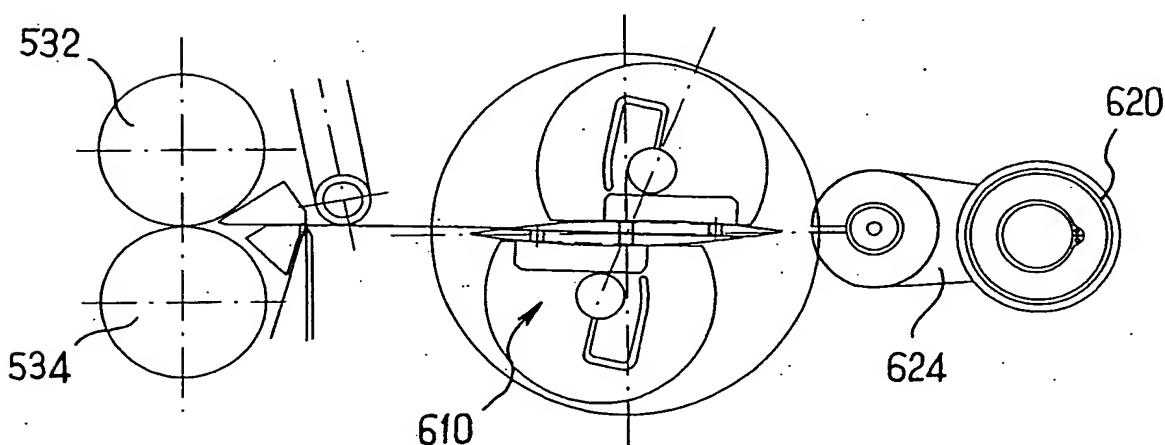


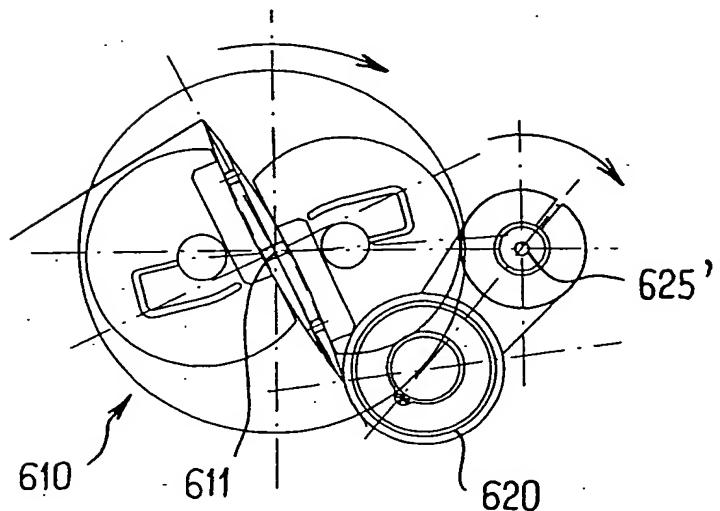
FIG. 45



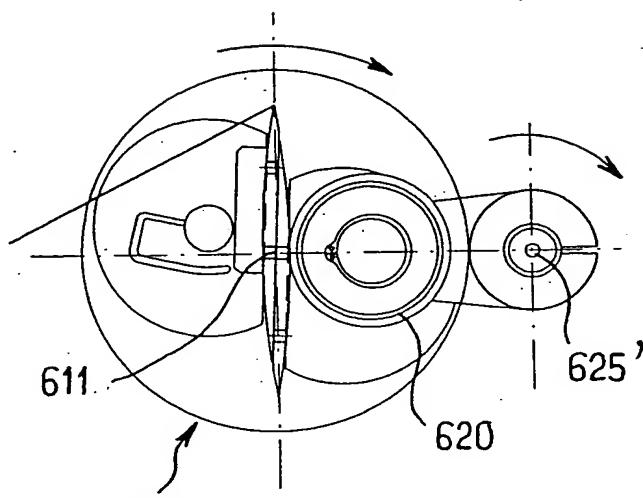
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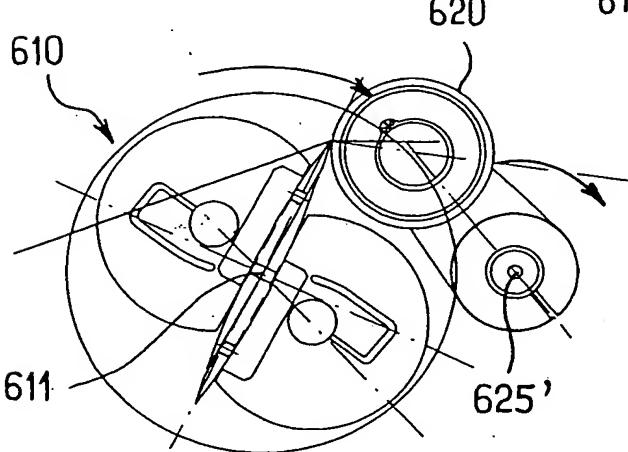
FIG\_46A



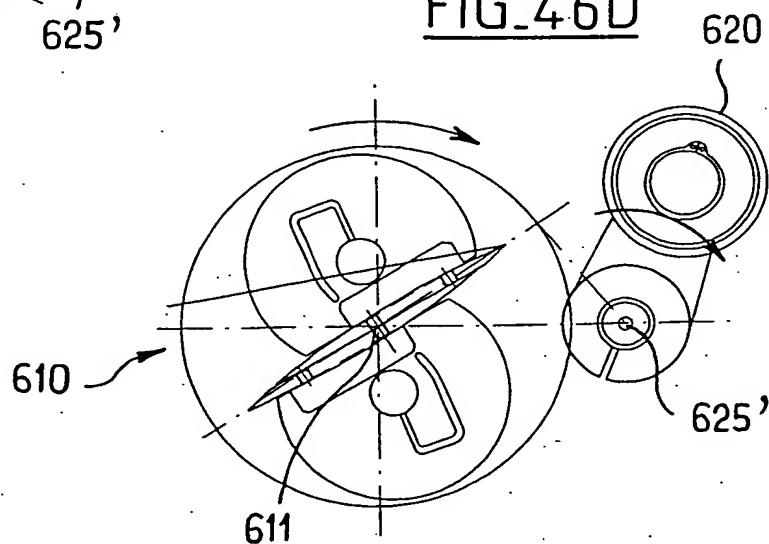
FIG\_46B



FIG\_46C



FIG\_46D



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FIG. 46E

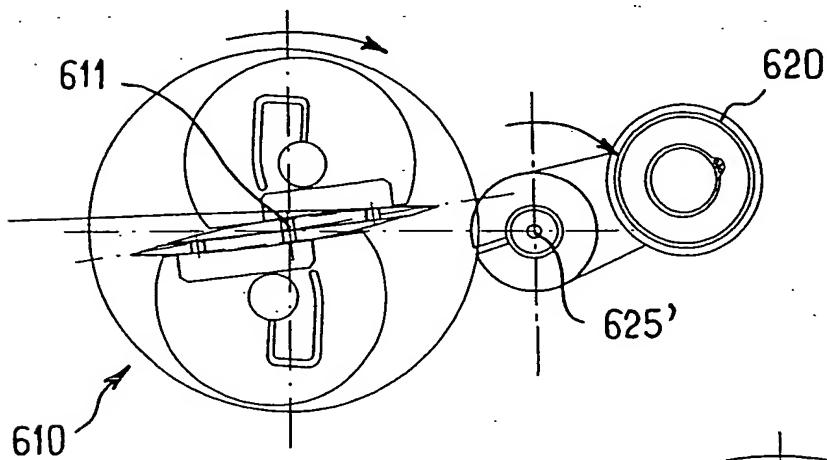


FIG. 46F

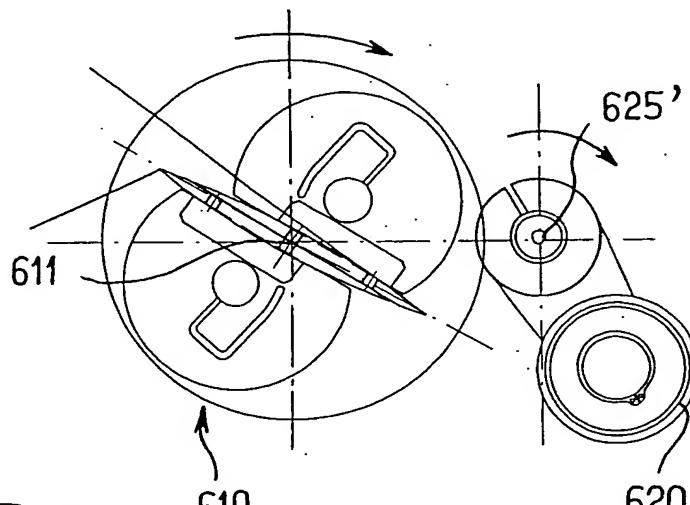


FIG. 46G

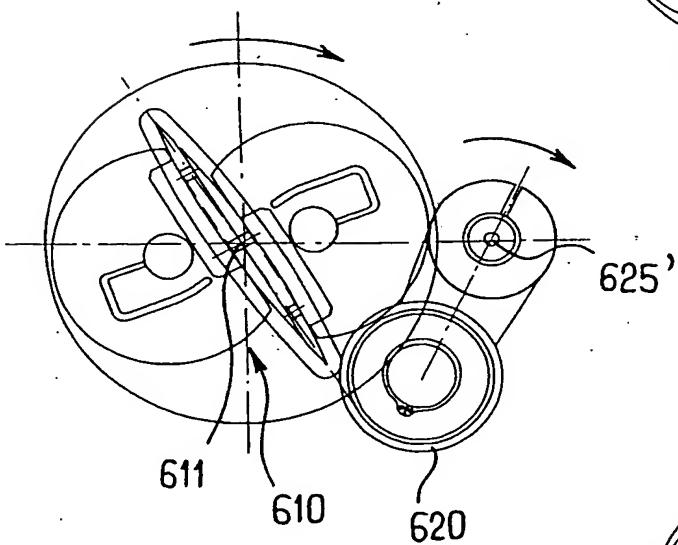
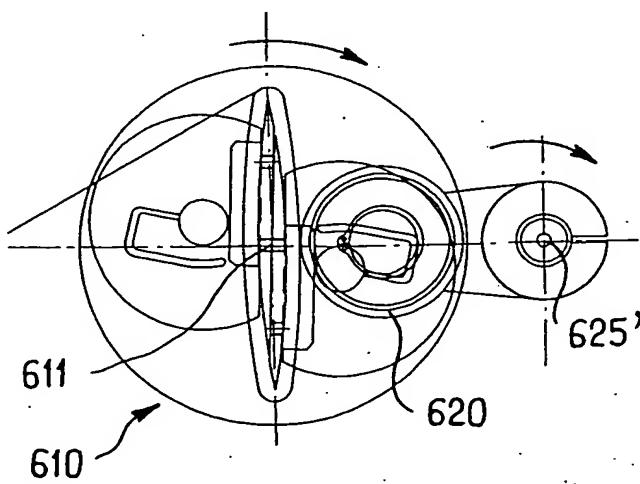


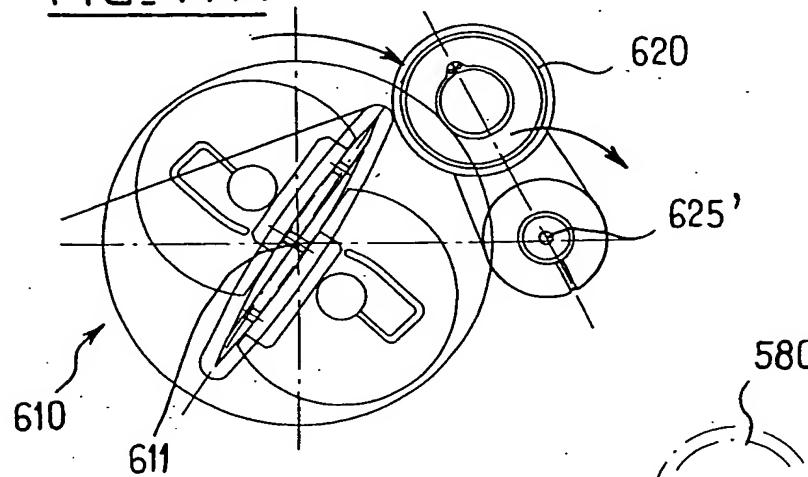
FIG. 46H



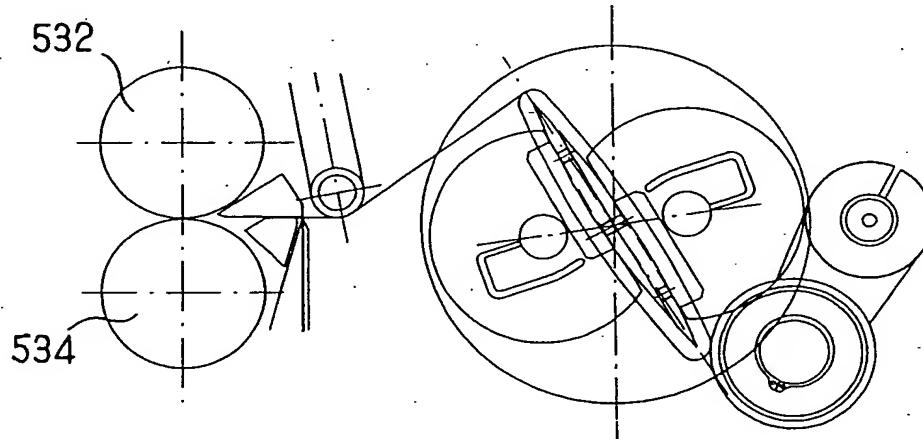
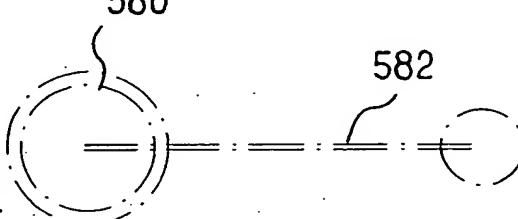
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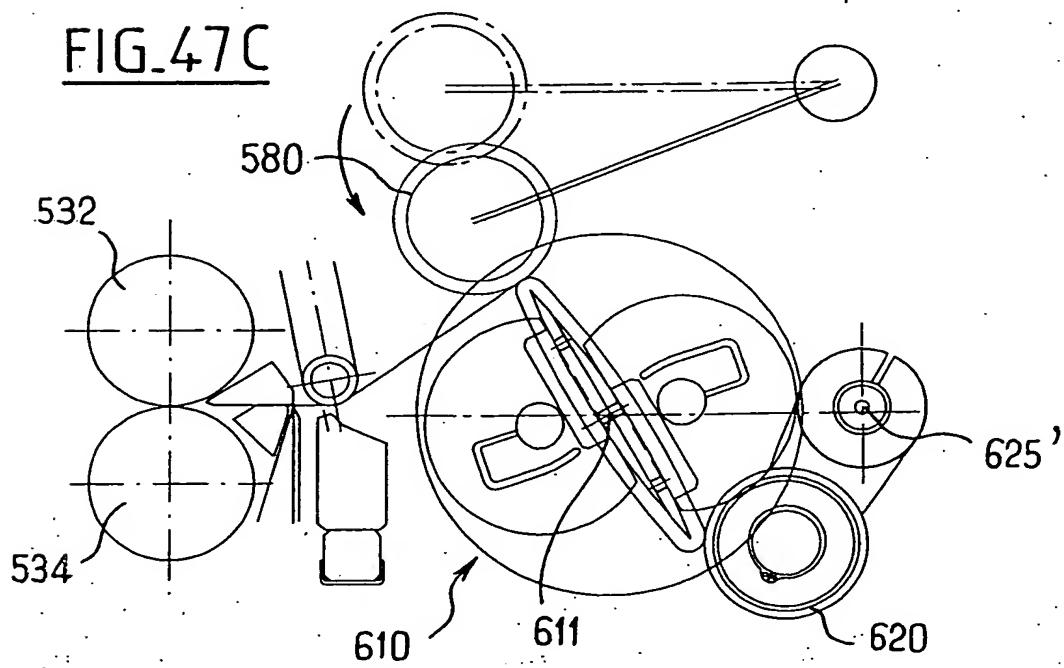
FIG\_47A



FIG\_47B



FIG\_47C



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FIG. 47D

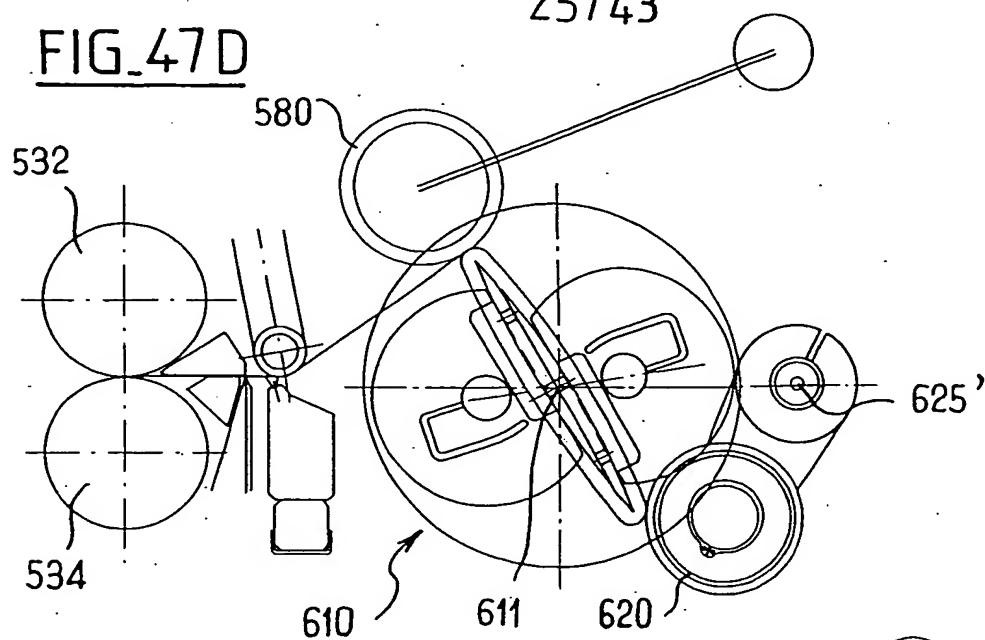


FIG. 47E

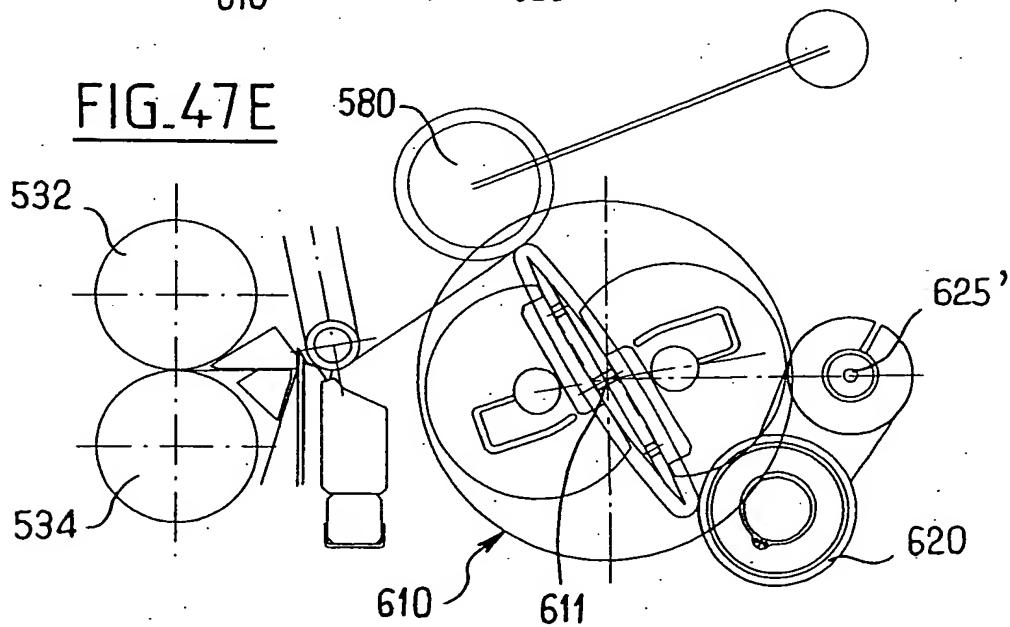
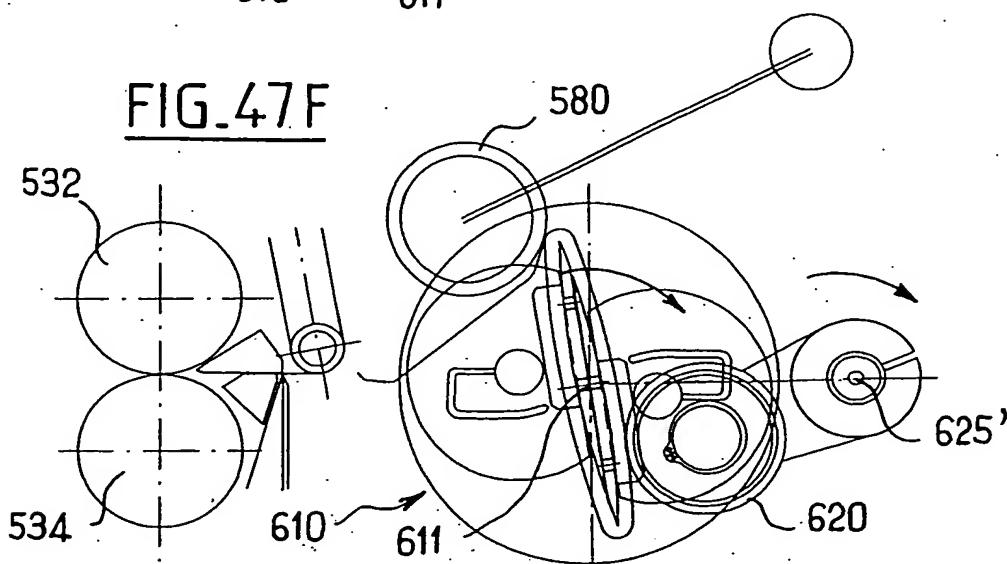


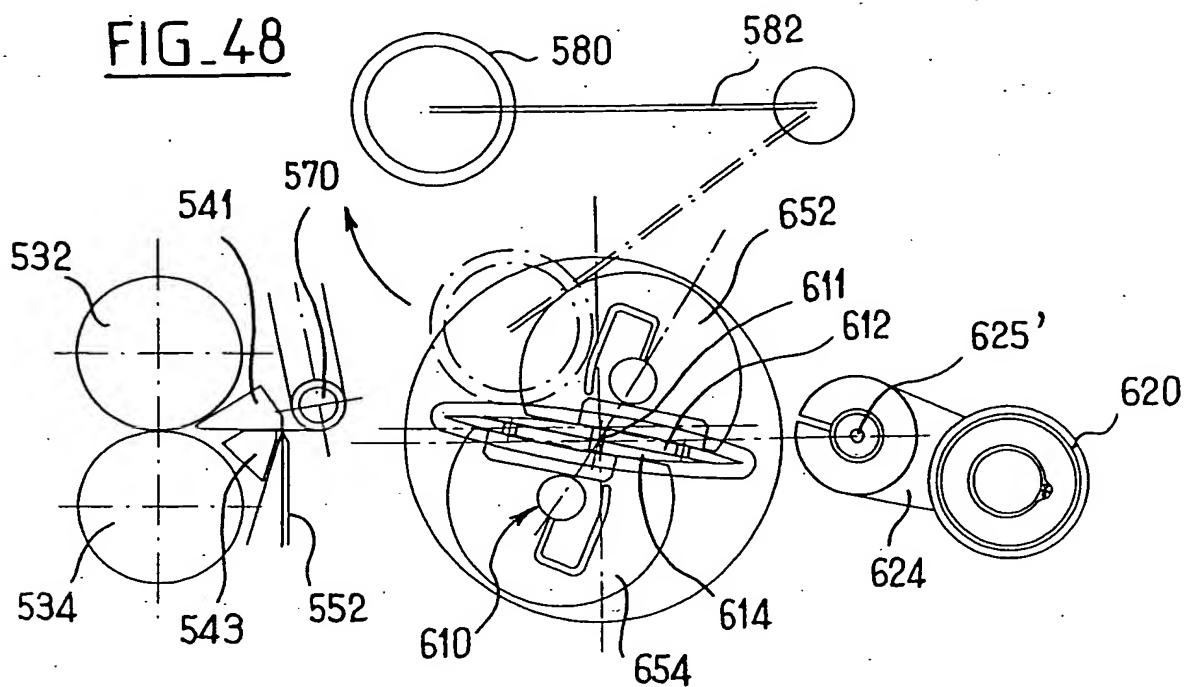
FIG. 47F



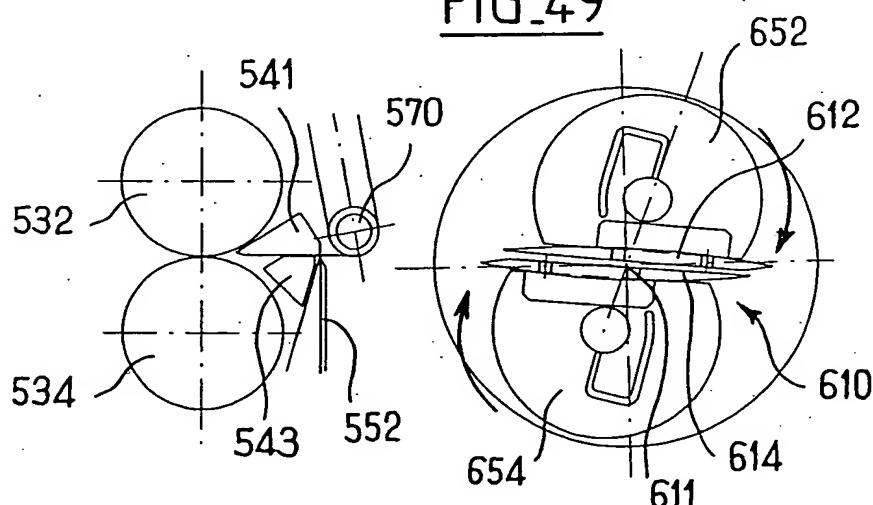
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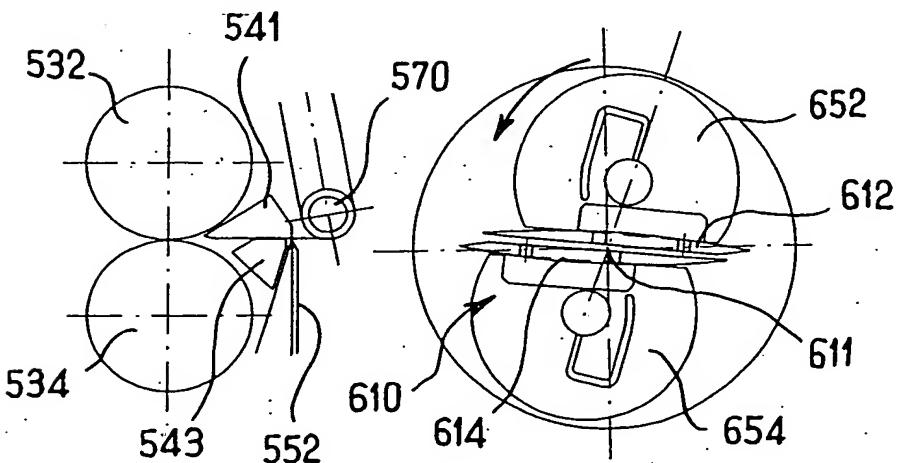
FIG\_48



FIG\_49



FIG\_50



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FIG. 51A

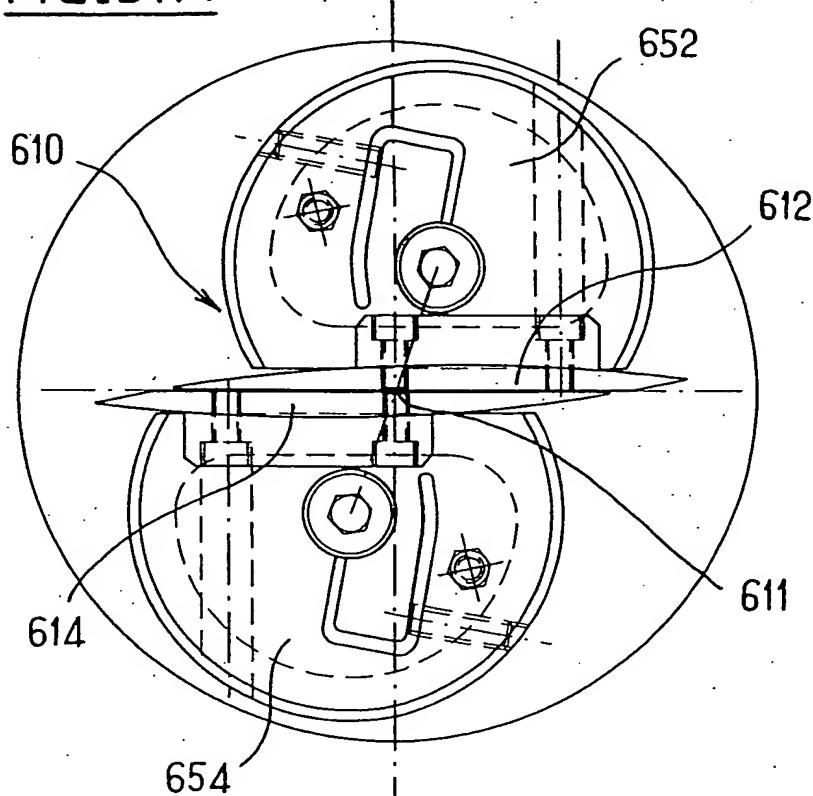
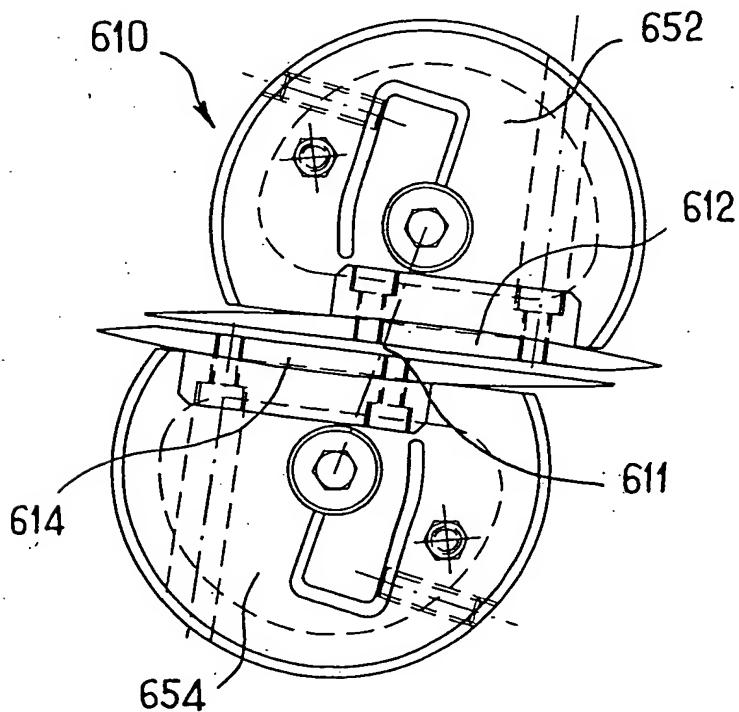


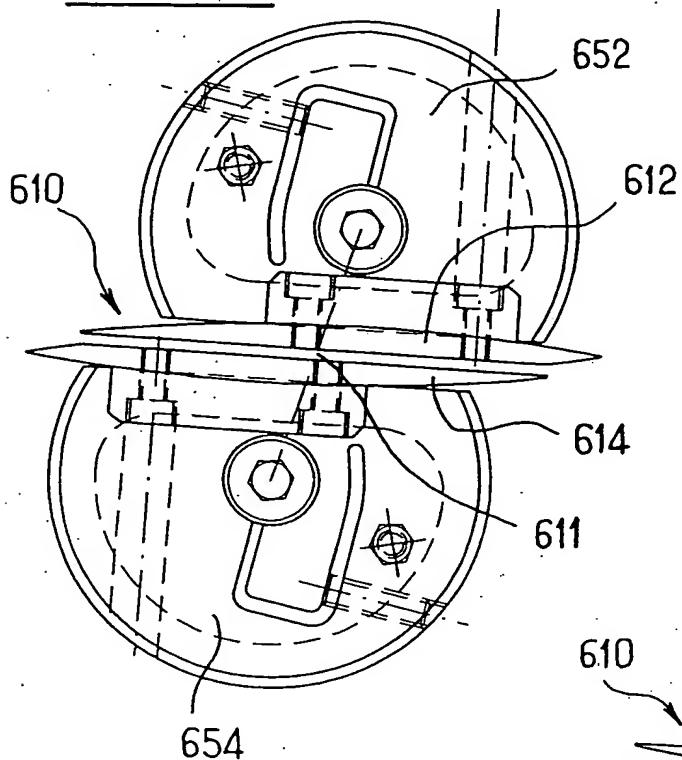
FIG. 51B



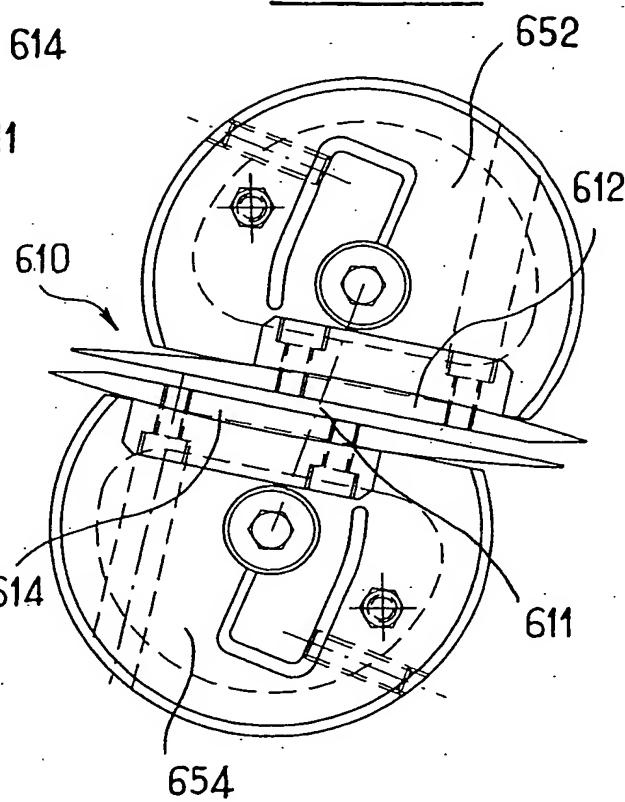
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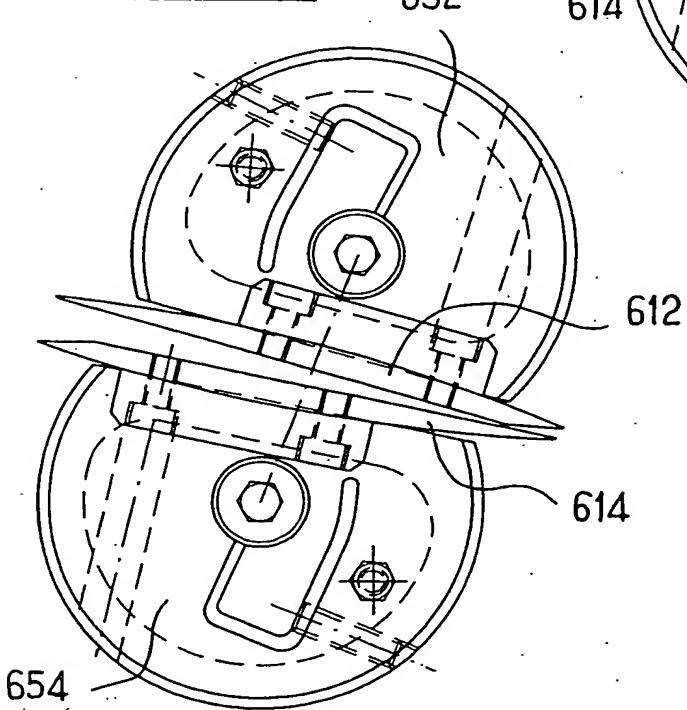
FIG\_51C



FIG\_51D



FIG\_51E



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FIG. 52A

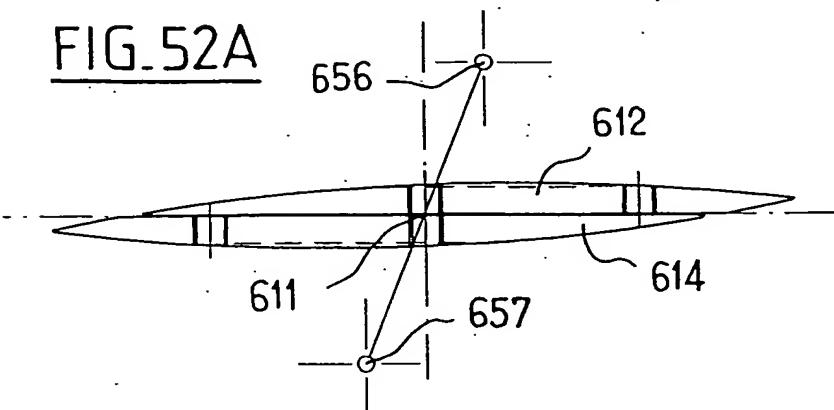


FIG. 52B

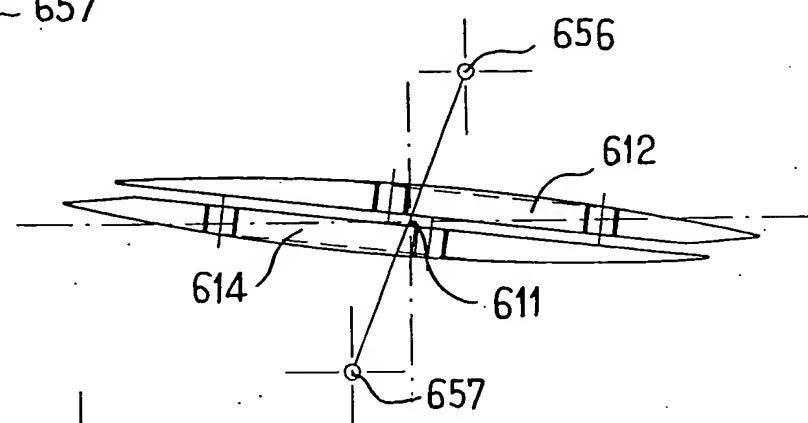


FIG. 52C

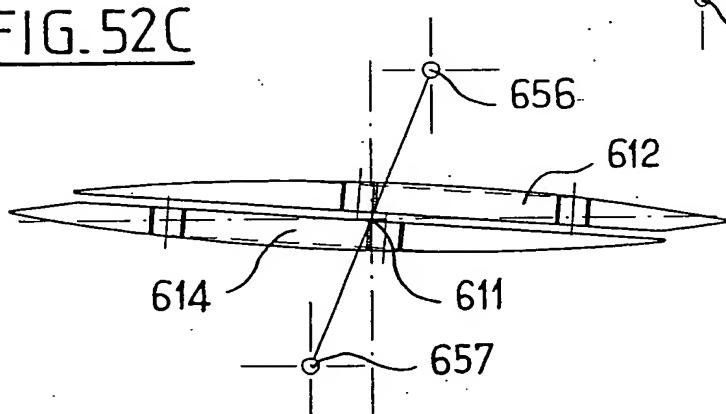


FIG. 52D

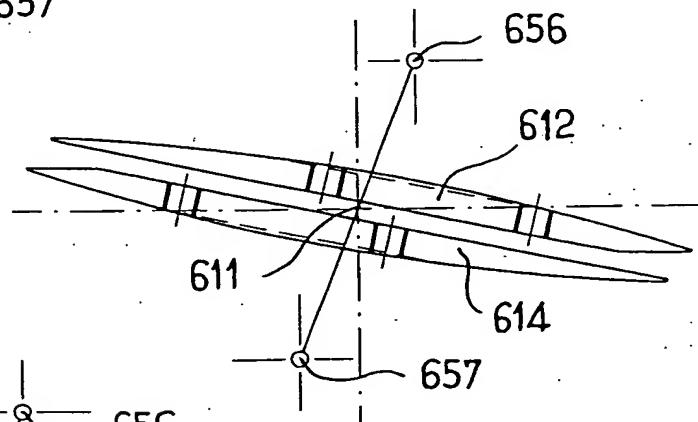
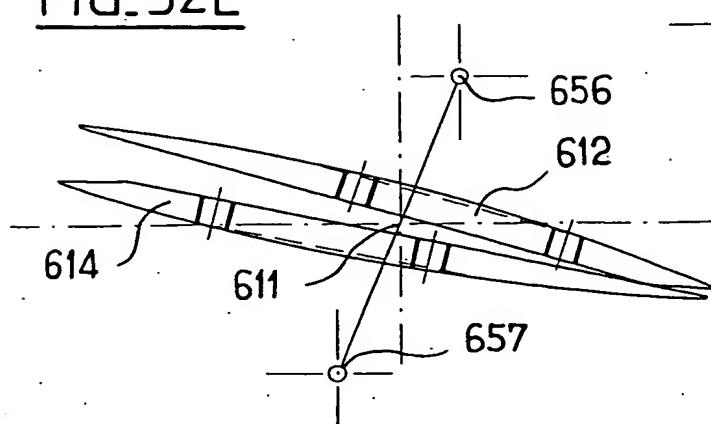


FIG. 52E



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FIG. 53A

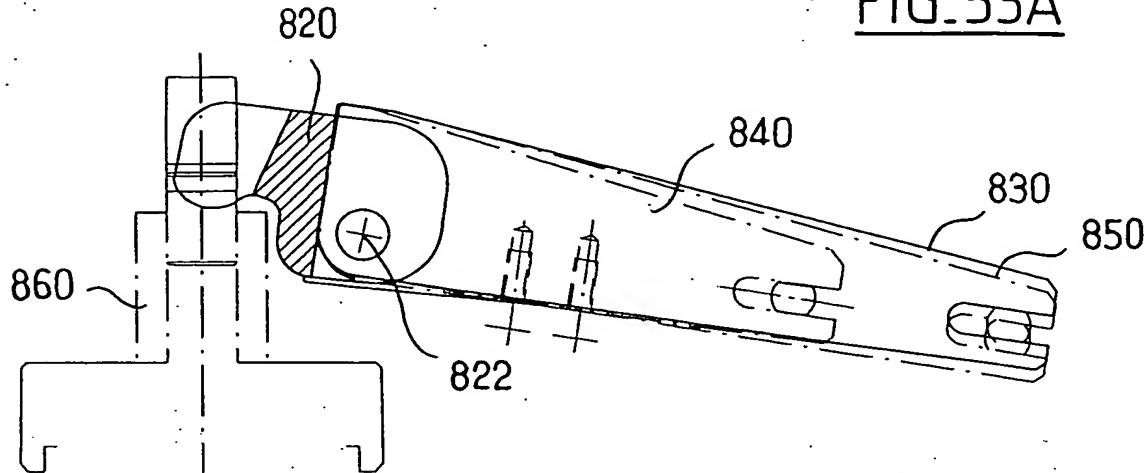


FIG. 53B

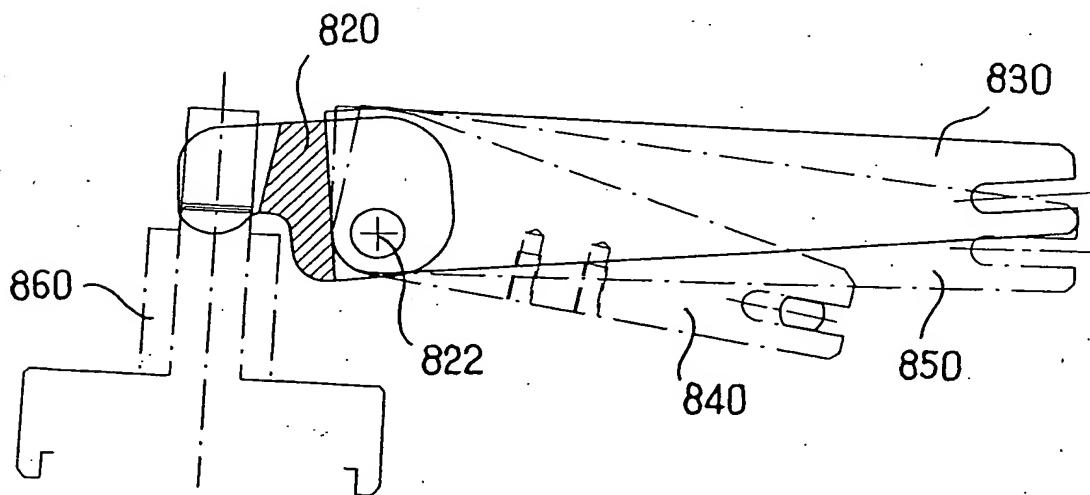
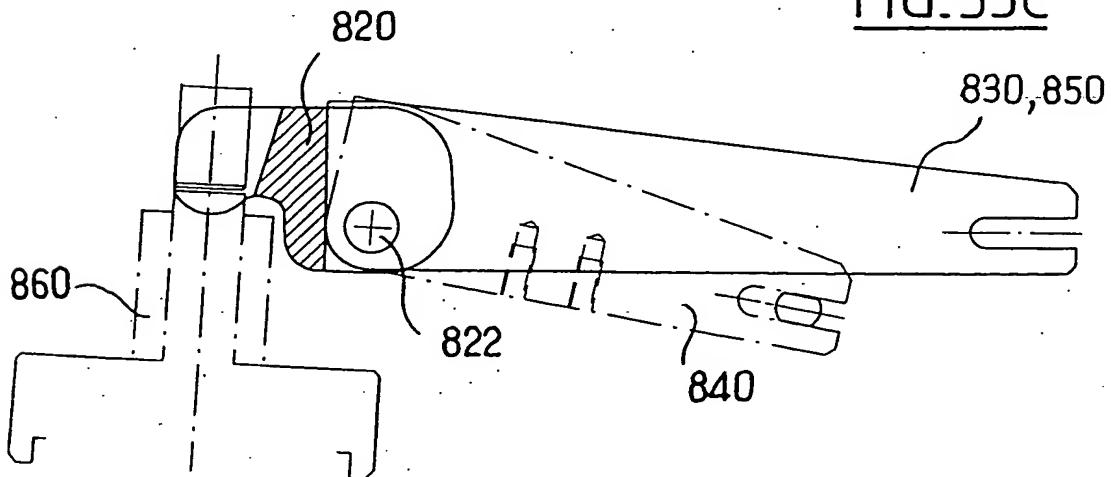


FIG. 53C



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FIG. 53D

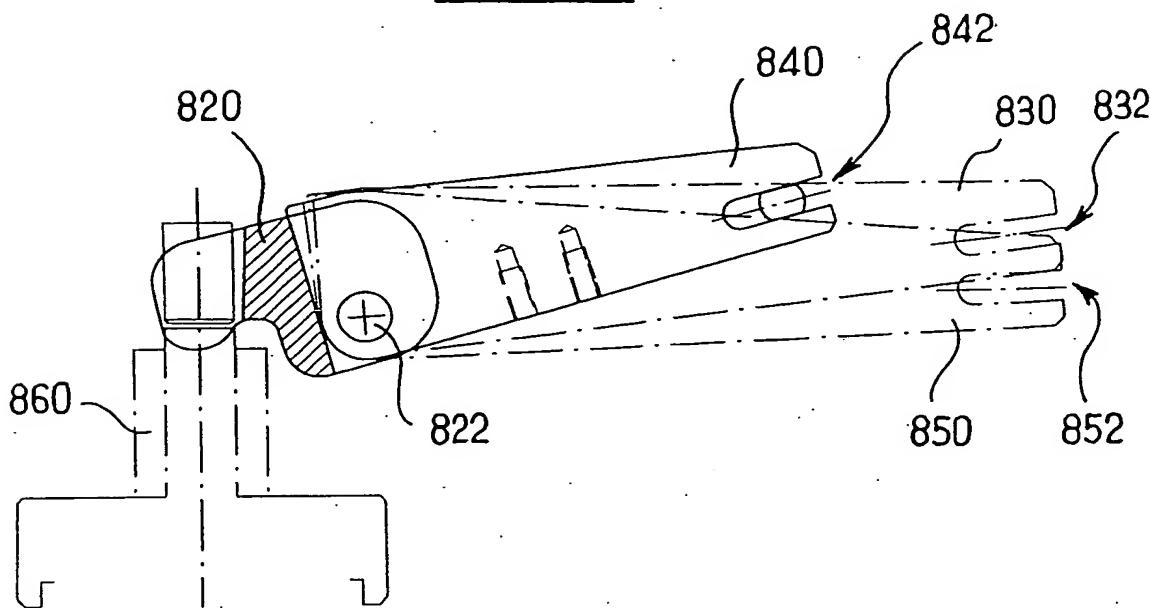
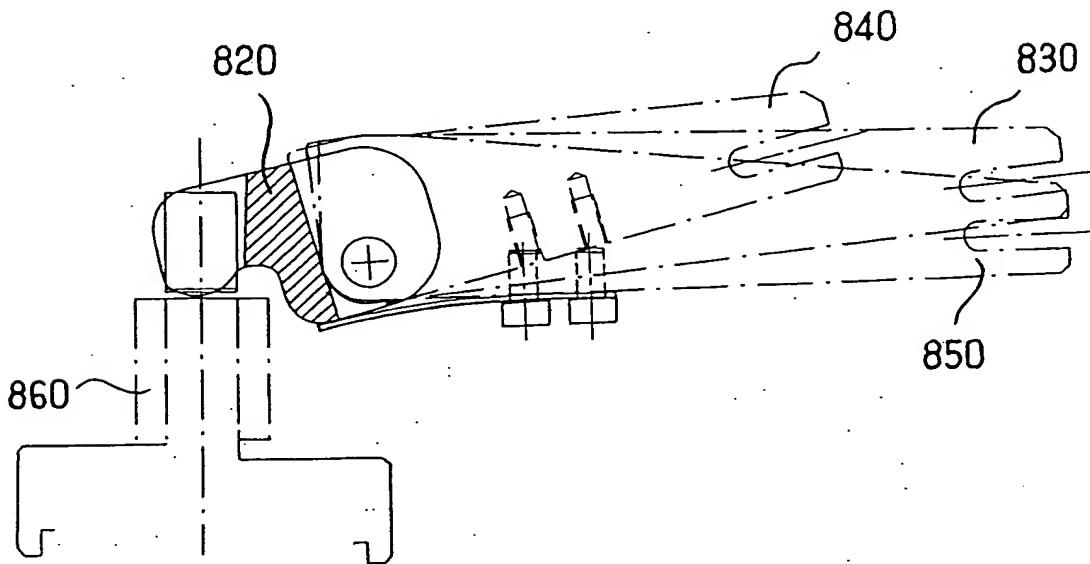


FIG. 53E



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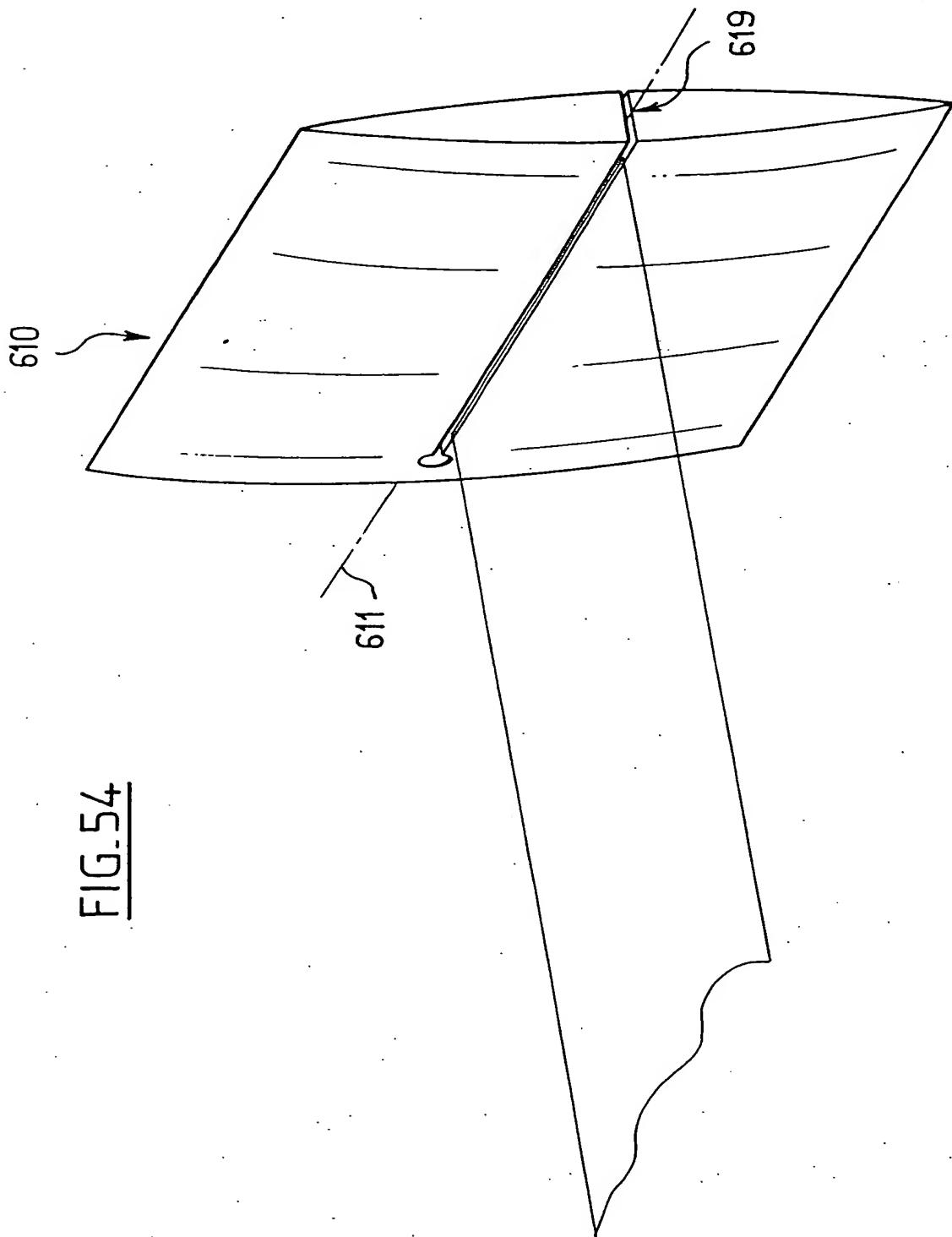


FIG. 54+

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FIG. 55A

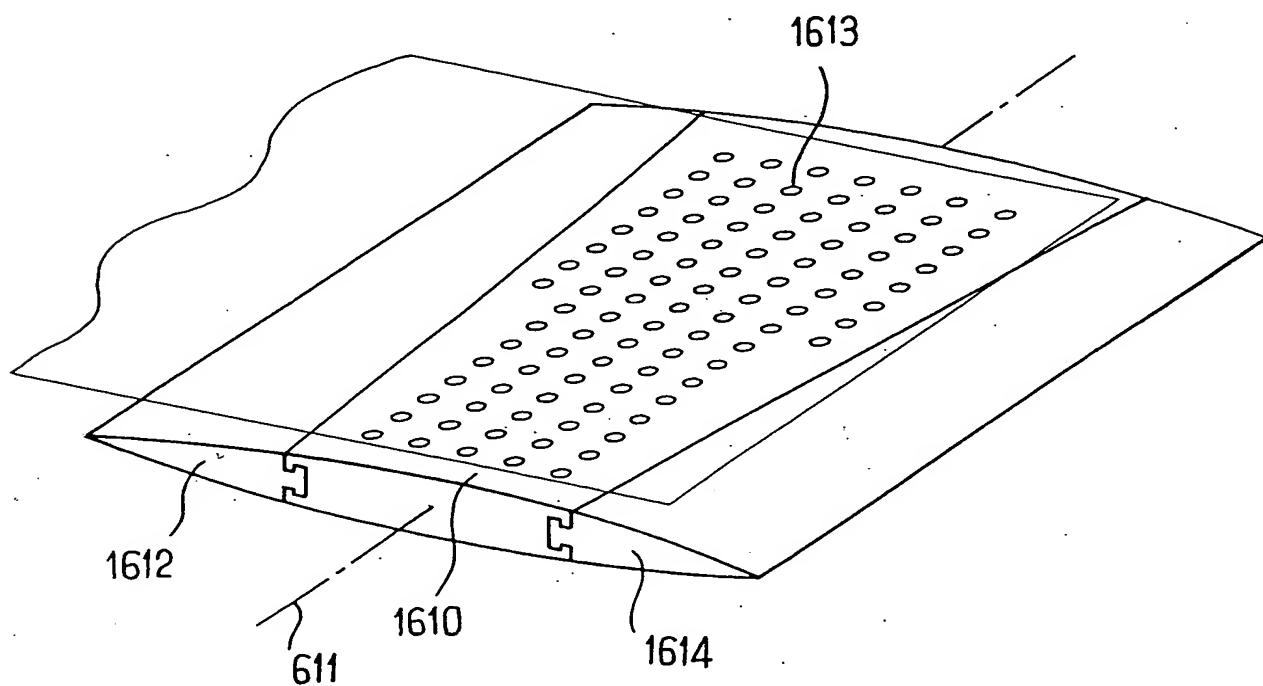
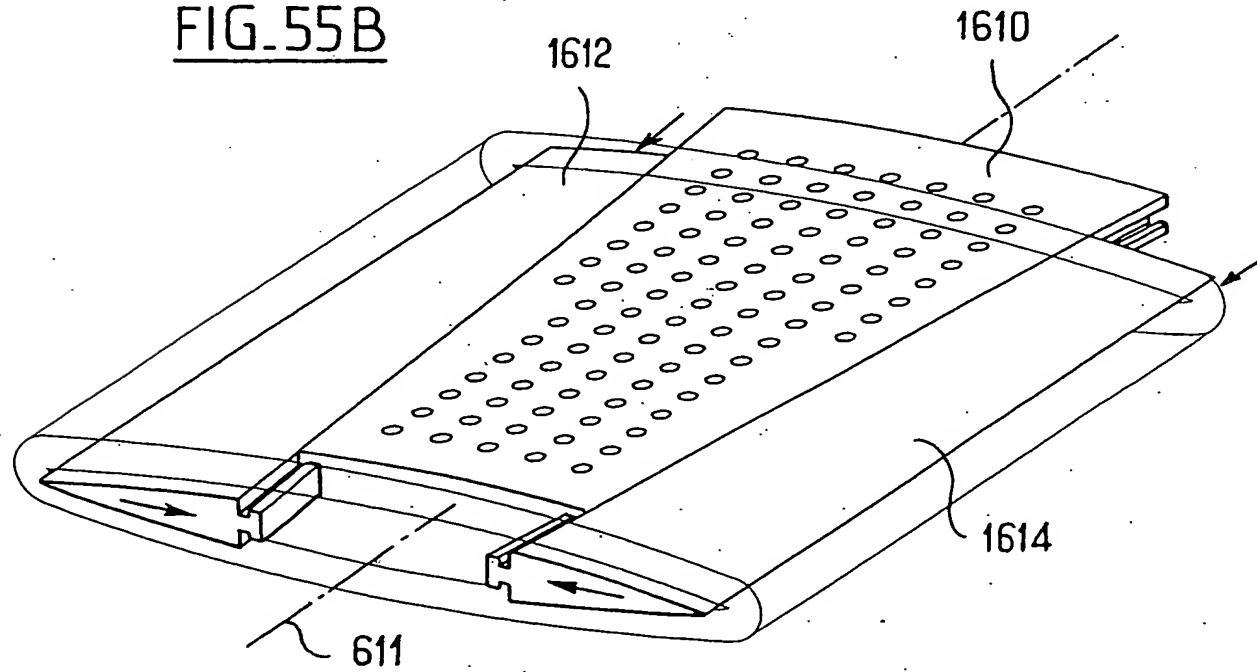


FIG. 55B



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FIG. 56C

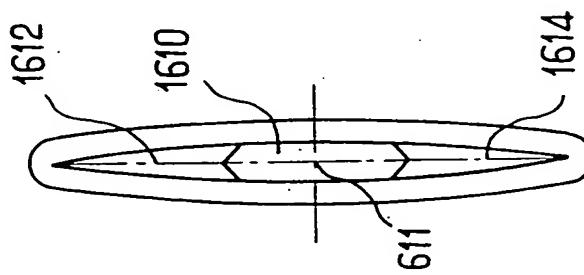


FIG. 56B

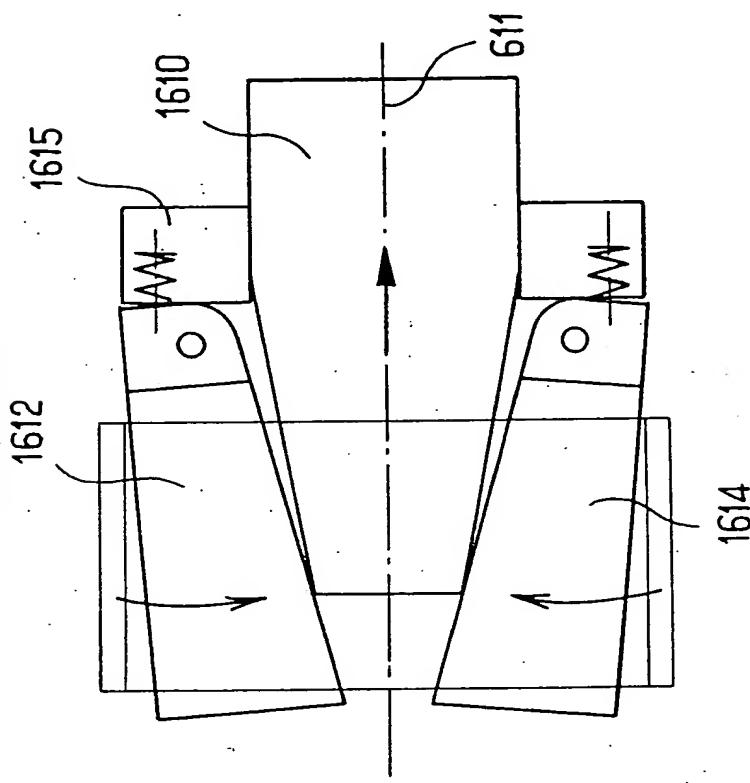
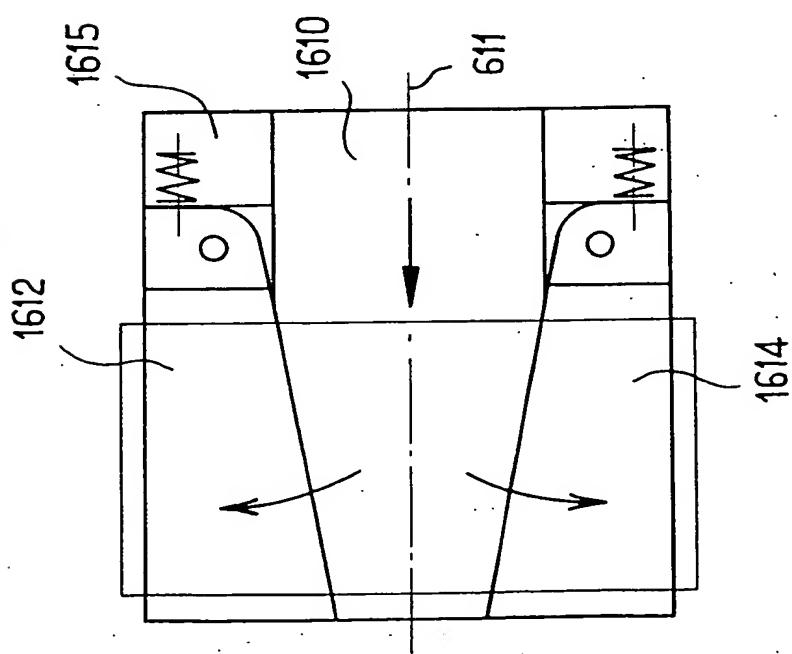


FIG. 56A



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FIG. 57

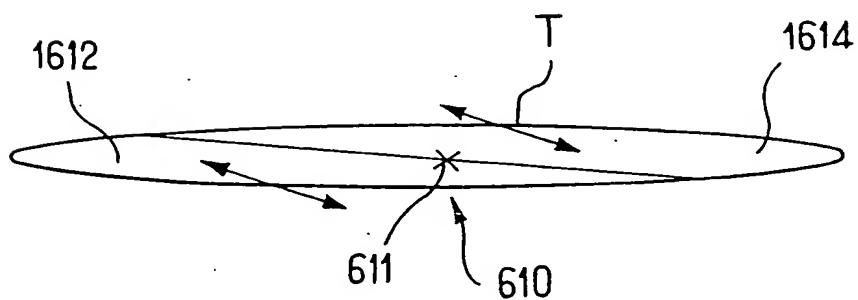


FIG. 58

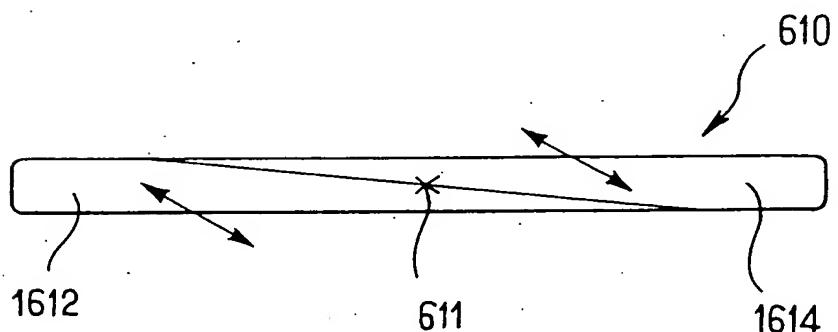
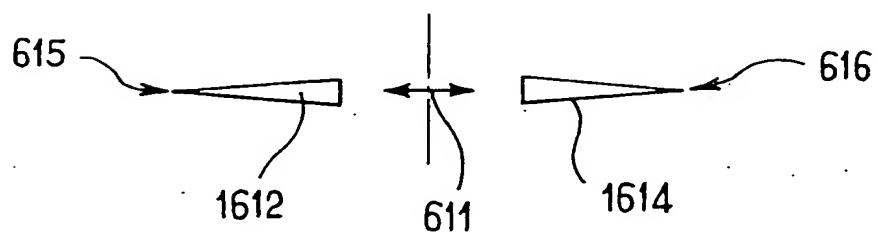


FIG. 59



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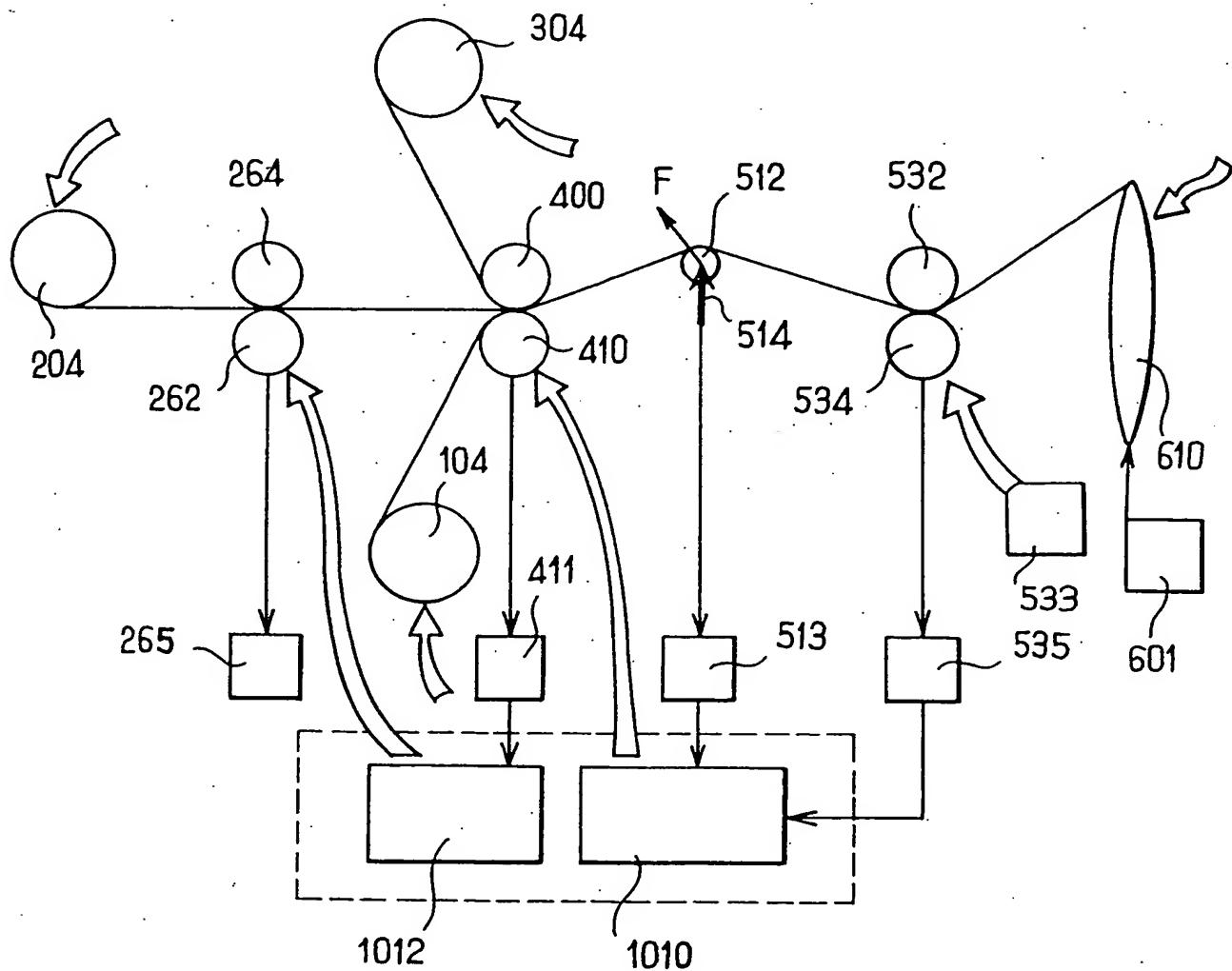


FIG. 60

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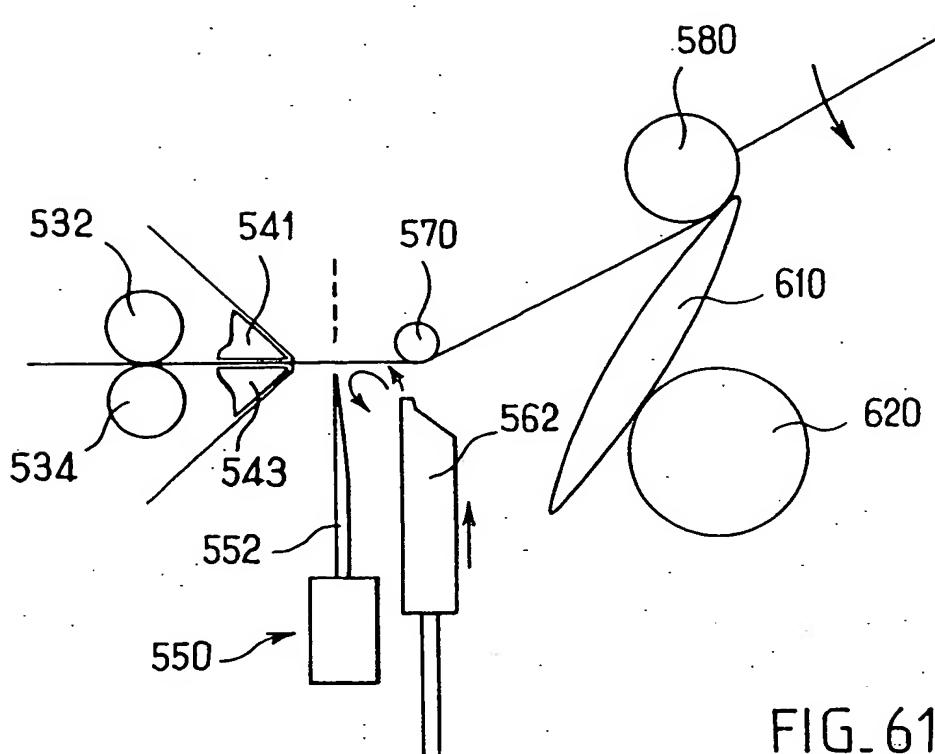


FIG. 61

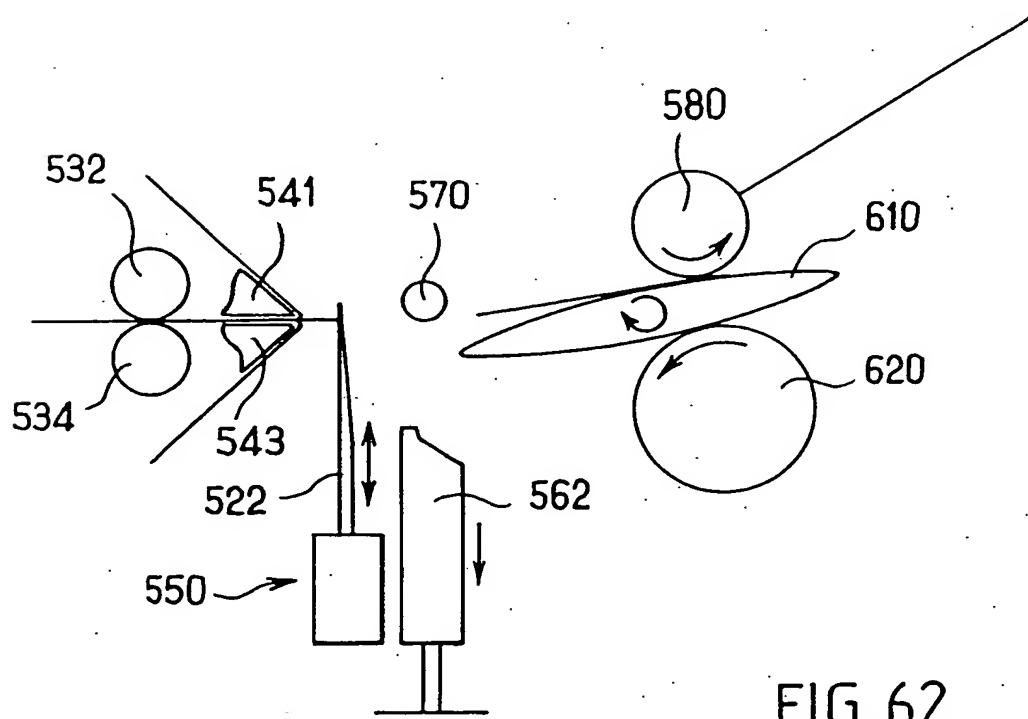


FIG. 62

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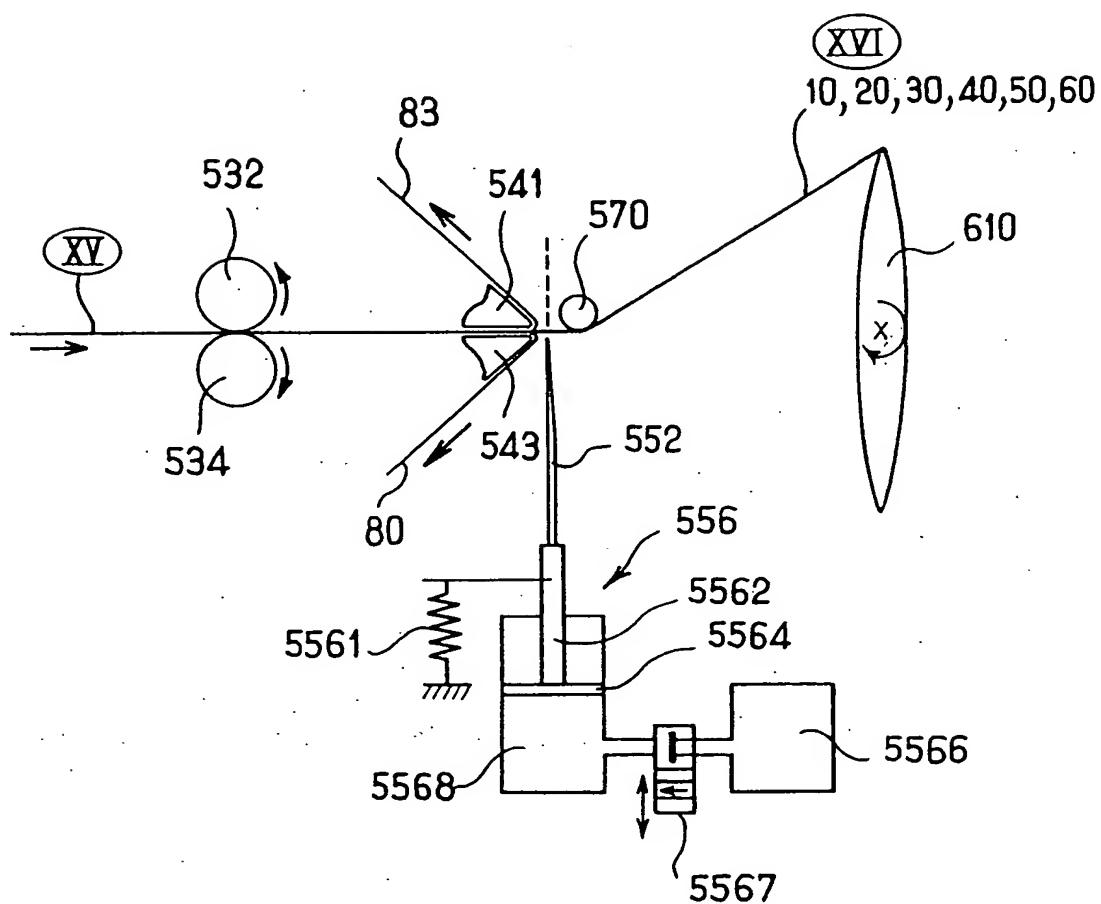


FIG. 63

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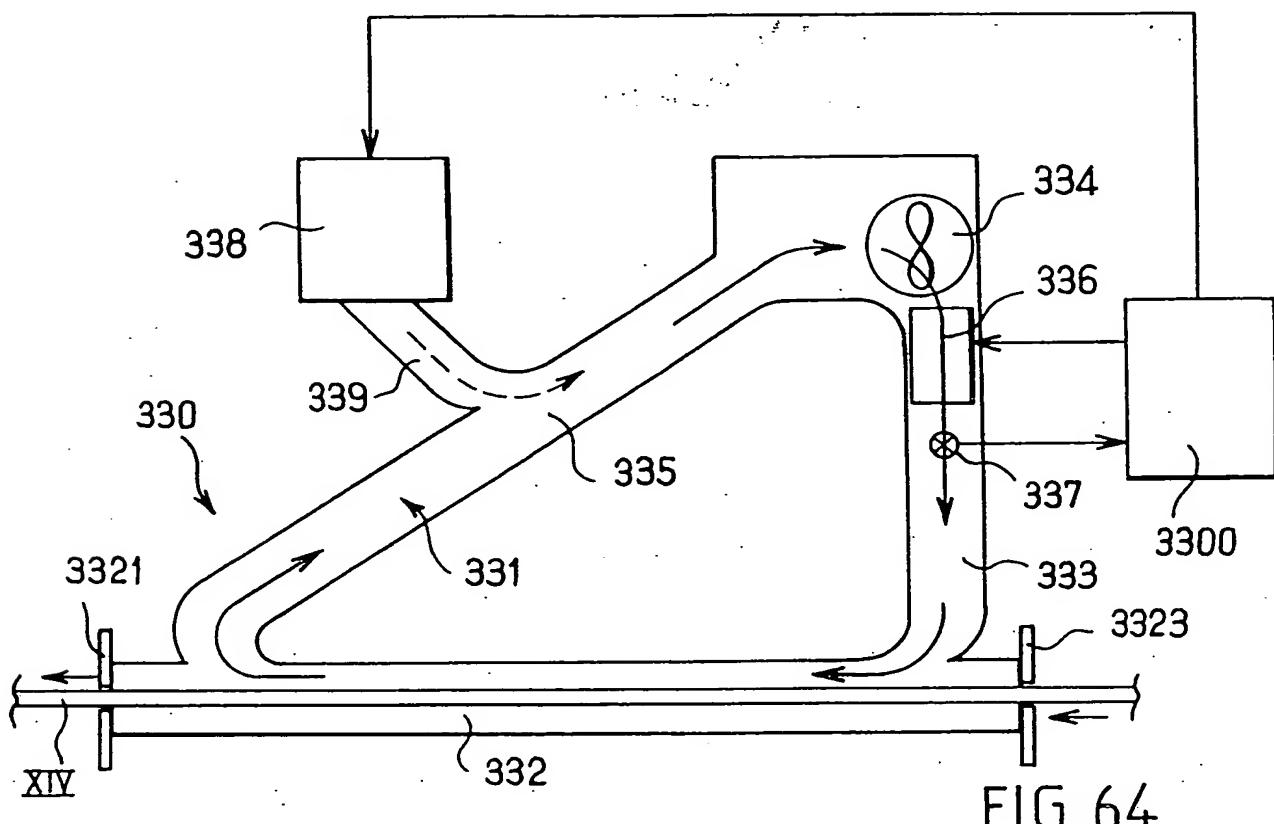


FIG. 64

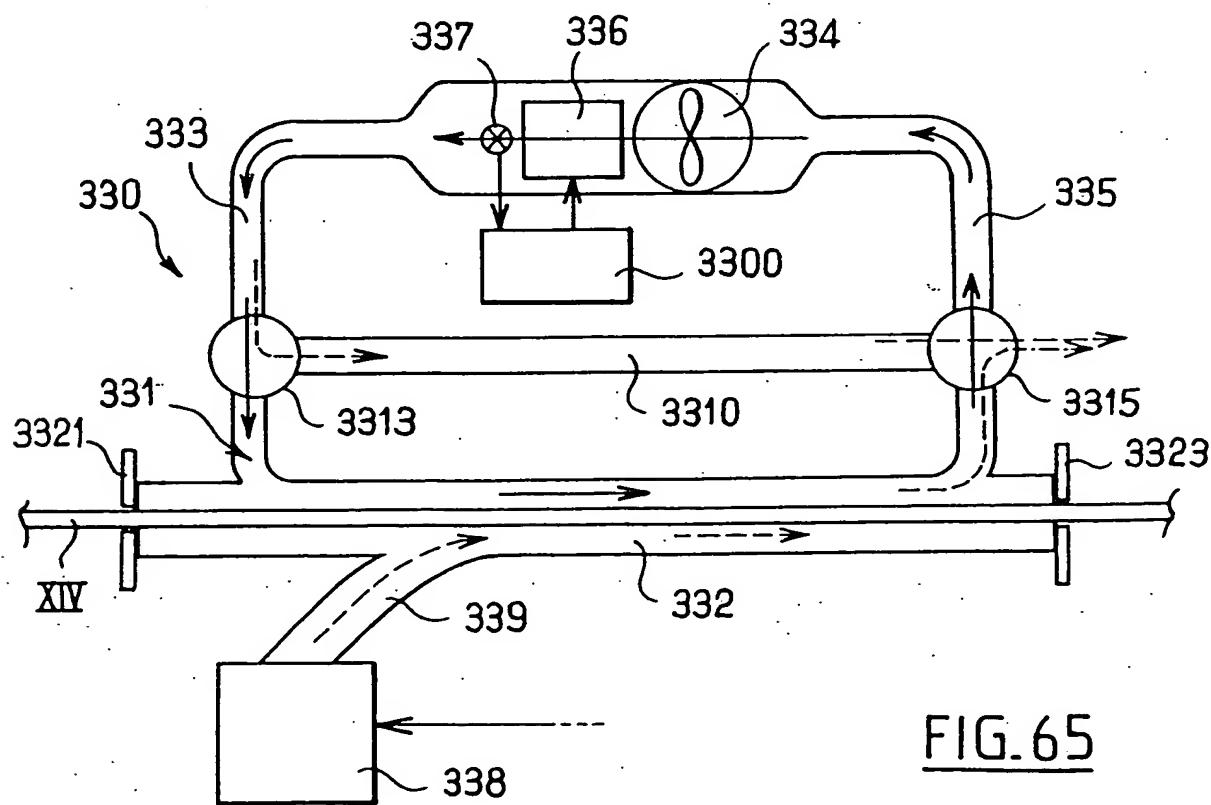
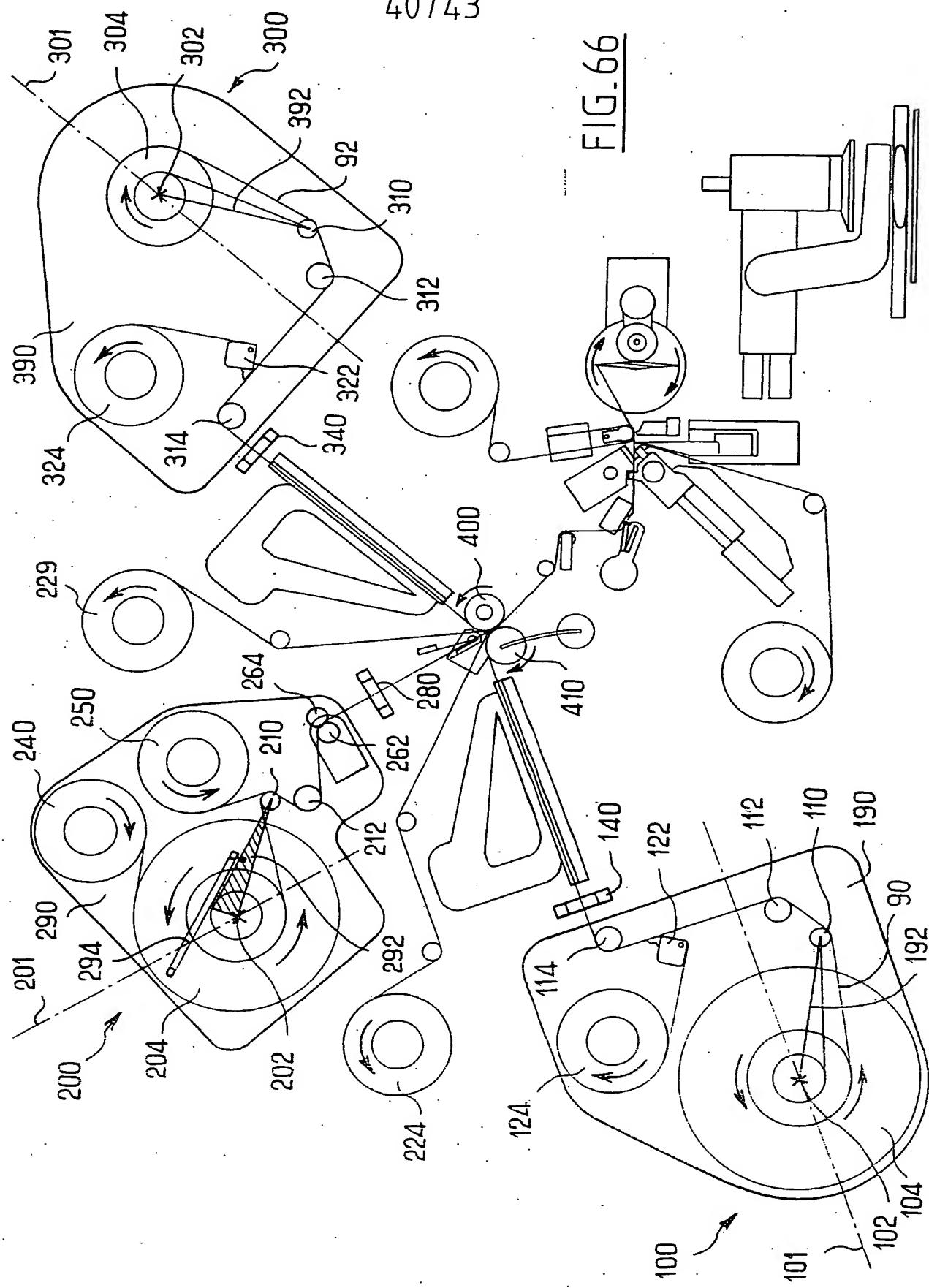


FIG. 65

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FIG. 66



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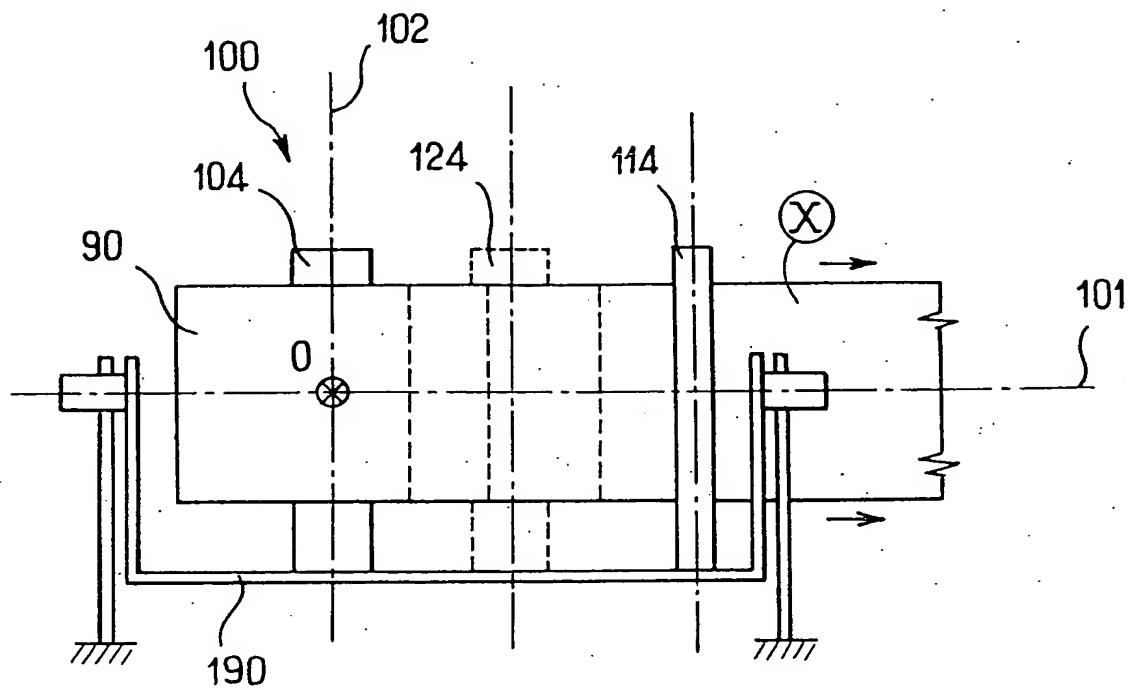


FIG. 67

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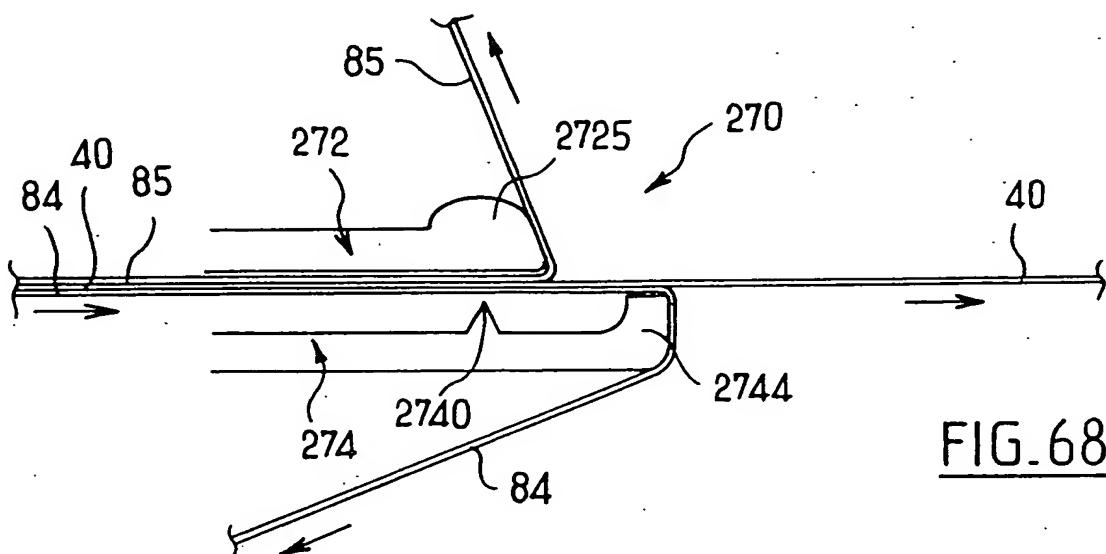


FIG. 68

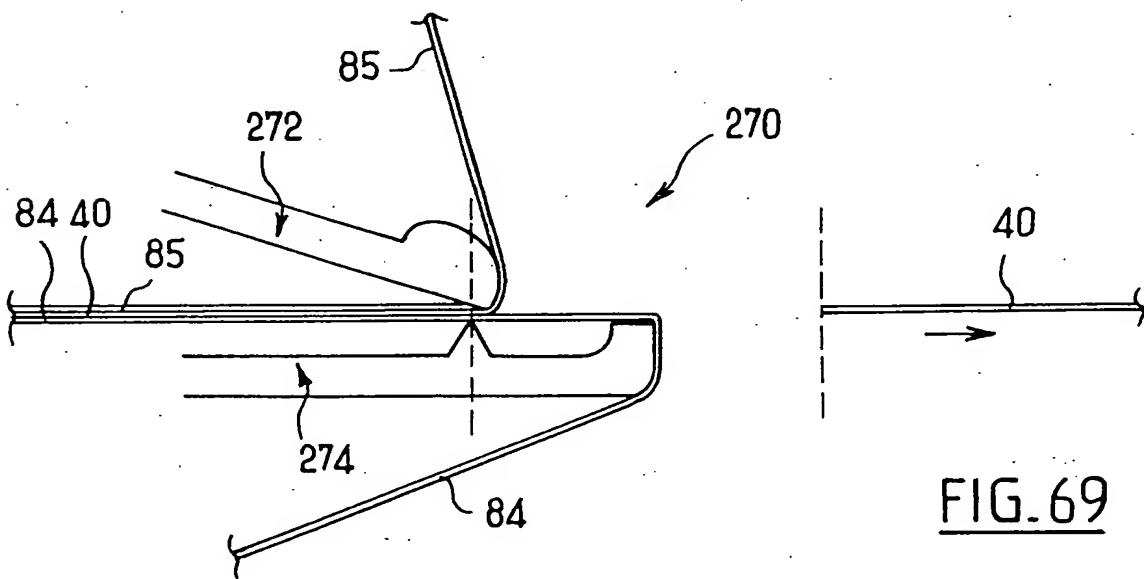


FIG. 69

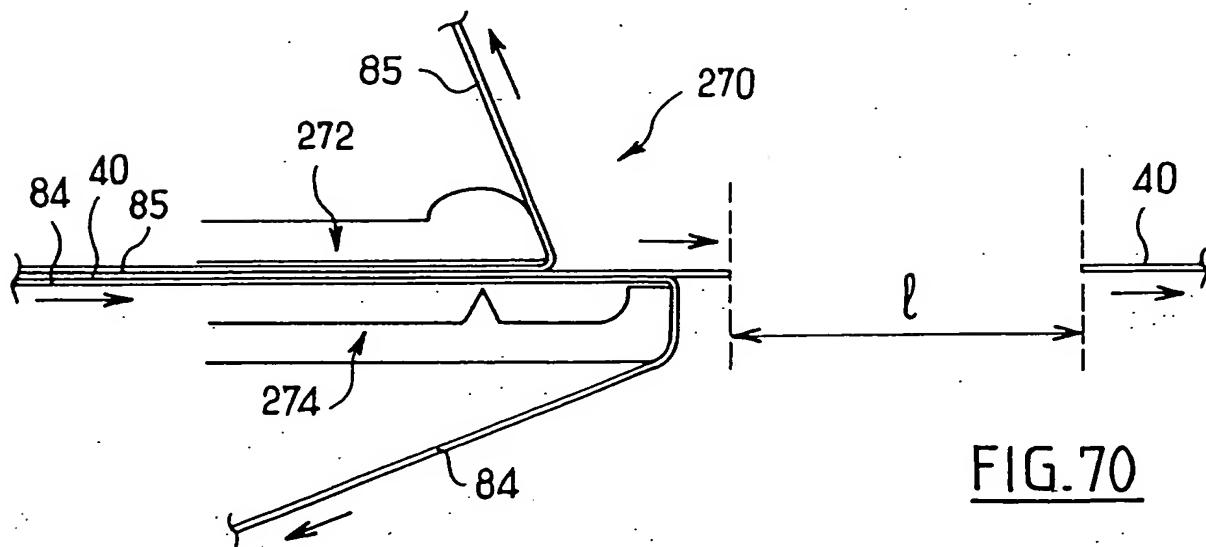


FIG. 70

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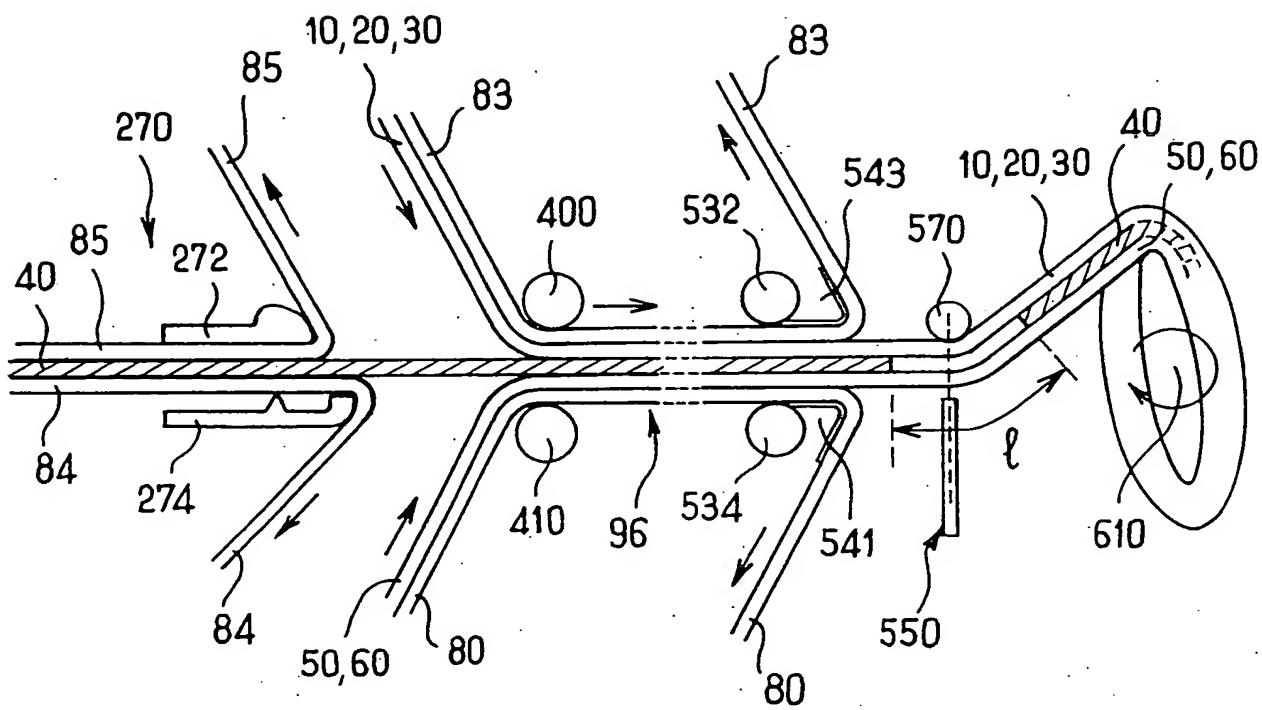


FIG. 71

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